

#93

DESCRIPTION OF MANUFACTURE



[Handwritten signature]

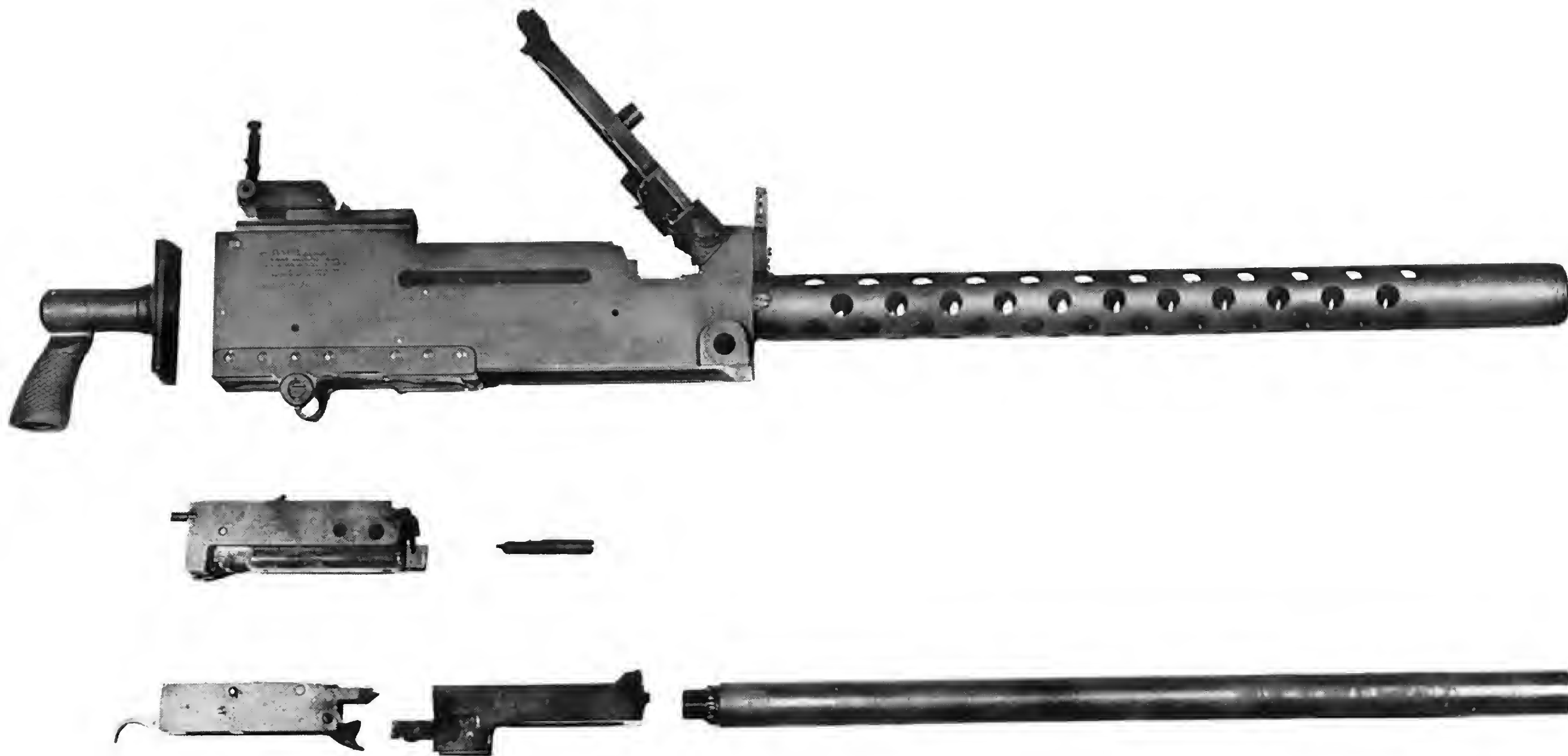
ITEM: GUN, BROWNING MACHINE, CAL. .30, M1919A4 (FLEX)

VOLUME 1 OF 1

CONTENTS: GENERAL INFORMATION AND COMPLETE SET OF

~~ROSTER CHARTS AND~~ DRAWINGS

DATE NOVEMBER 1949



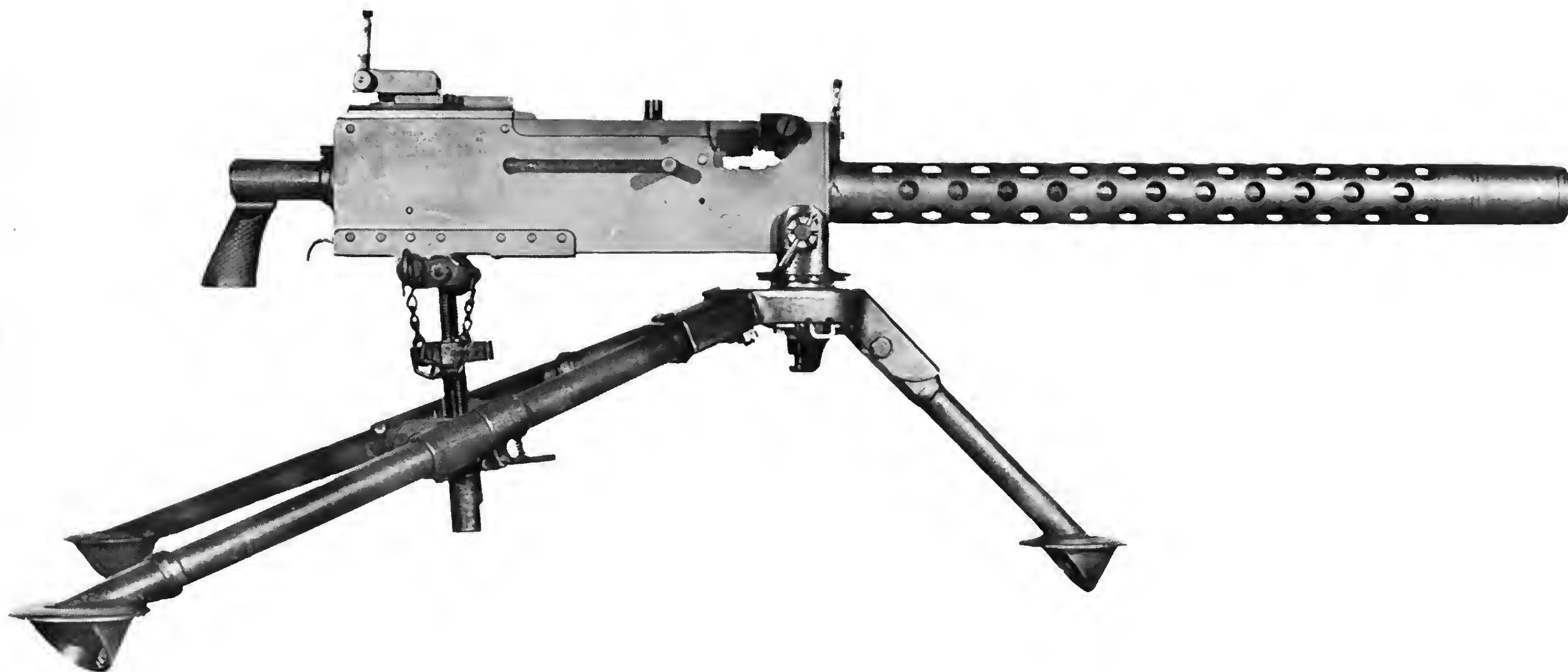
720-10518

May 18, 1944

ROCK ISLAND ARSENAL

ORDNANCE DEPARTMENT

Browning Machine Gun, Cal..30, M1919A4. Flexible, with principal components.



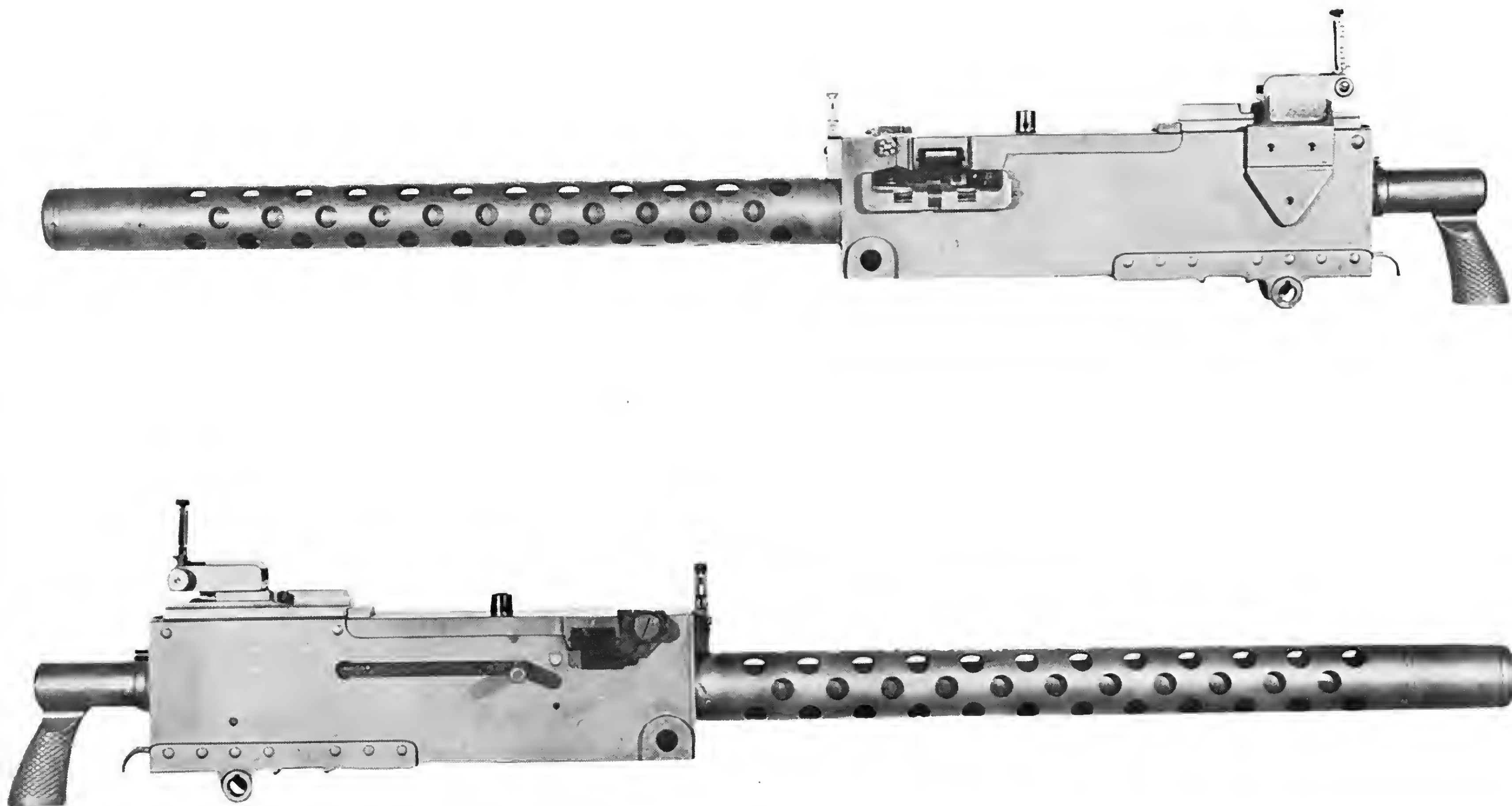
720-10521

May 18, 1944

ROCK ISLAND ARSENAL

ORDNANCE DEPARTMENT

Browning Machine Gun, Cal..30, M1919A4 on Mount, Tripod, Cal..30, M2.



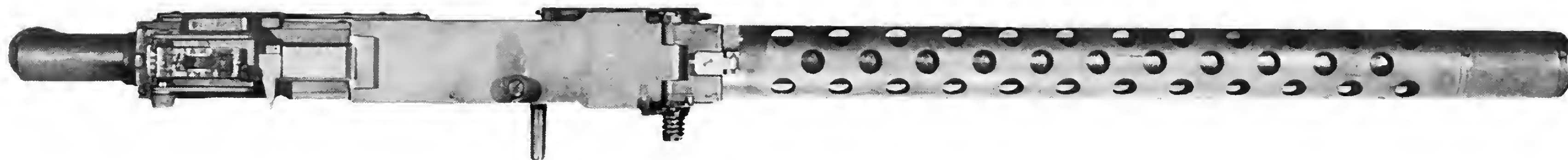
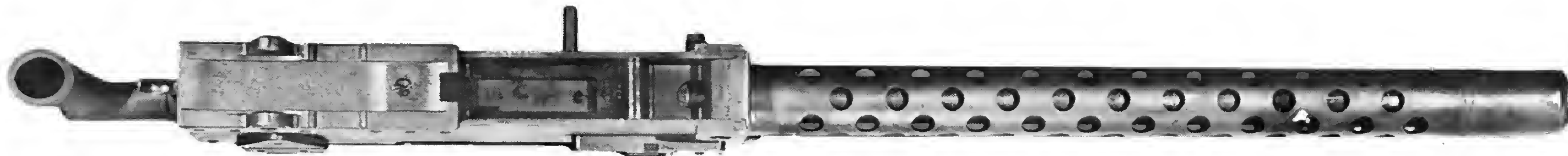
720-10519

May 18, 1944

ROCK ISLAND ARSENAL

ORDNANCE DEPARTMENT

Browning Machine Gun, Cal..30, M1919A4. Right and left side.



720-10520

May 18, 1944

ROCK ISLAND ARSENAL

ORDNANCE DEPARTMENT

Browning Machine Gun, Cal..30, M1919A4. Top and bottom.

LINE NUMBER	TITLE	DRAWING NUMBER	DRAWING NUMBER	DRAWING NUMBER	DRAWING NUMBER	DRAWING NUMBER	DRAWING NUMBER	DRAWING NUMBER
1	LIST OF DRAWINGS AND SPECIFICATIONS	51-84-1	D5508476	C64321	B6008503	A5005363	AS196283	BBFX1
2	RIGHT SIDE VIEW	51-84-2	D6508259	C5508452	B6008322	A9374	AS196284	BCLX11
3	PLAN VIEW	51-84-3	D6528106	C5508461	B6008823	A5013154	A5238204	BCLX3
4	LONGITUDINAL SECTION	51-84-4	D6535233	C5508462	B6008324	A6013155	A6008825	BEAX1
5	SECTIONAL VIEWS	51-84-5	D6535234	C5508467	B6017462	A5013157	A6147225	BEAX4
6			D6535236	C5508471	B6017469	A5013157A	A7106092	BFAX1
7	COMBINED LIST OF ALL PARTS, SPARE		D6535392	C5508472	B6017485	A5013162	A7106099	BFOX1
8	PARTS, EQUIPMENT AND TOOLS	C7122999	D6535393	C5545941	B6017494	A5013166	A7106070	URAX6
9		SHEETS 1-15	D6535408	C5545965	B6017497	A5013167	A7110440	
10			D6535410	C5545963	B6017503		A7123315	
11	LIST OF ALTERNATIVE MATERIALS	B6221040	D6535411	C5564132	B6017508	A20495	A7133164	
12		SHEETS 1-17	D6544087	C5564133	B6017509		A7133165	
13			O7116476	C5564137	B6017511	A135255	A7162630	
14	MATERIAL SPECIFICATIONS	B647588		C5564142	B6017513		A7162631	
15		B647588A		C5563469	B6110312		A7162632	
16		B647588B		C7106872	B6131258	A5013249	A7162633	
17		B647588C			B6131317	A5013258	A5013700	
18					B6134059	A5020490	A5020615	
19	PART NUMBER INSTRUCTIONS	B6169913			B6144237	A5020491	A5163397	
20					B6147212	A5020503	A5163398	
21	FINDING DIAGRAMS				B6147214	A5020505		
22					B6147216	A5020509		
23	CASING ASSEMBLY	D6535358			B6147217			
24	FRAME, LOCK, ASSEMBLY	D5509102			B6147224			
25					B6147228	A5020513		
26					B6147229	A5020514		
27	FRAME, LOCK, R.H. ASSEMBLY	C5509180			B6147230	A5020520		
28	FRAME, LOCK, L.H. ASSEMBLY	C5509181			B6147231	A5020522		
29	PIN, FIRING, ASSEMBLY	C5509186			B6212654	A5020527		
30	COVER, BELT FEED, ASSEMBLY	C5509801			B6221301	A5020530		
31	LEAF, REAR SIGHT, ASSEMBLY	C5545364			B6261101	A5020562		
32	COVER, ASSEMBLY	C5564096			B7162248	A5020567		
33	EXTENSION, BARREL, ASSEMBLY	C5564139				A5020570		
34	PLATE, SIDE, L.H. ASSEMBLY	C5564222				A5020577		
35	PLATE, SIDE, R.H. ASSEMBLY	C5564224				A5020581		
36	SIGHT, REAR GROUP, ASSEMBLY	C5564906				A5020589		
37	EXTRACTOR, ASSEMBLY	C5621076				A5020600		
38	PLATE, BACK W/BUFFER, ASSEMBLY	C7100059				A5020601		
39						A5020627		
40						A5020711		
41	CATCH, COVER	B6008757				A5024602		
42	PIVOT, BELT FEED LEVER, GROUP ASSEMBLY	B6110529				A5024603		
43	PLUNGER, BARREL, ASSEMBLY	B6131251				A5024605		
44	PIN, ASSEMBLY	B6131253				A5135051		
45	PIN, BELT FEED PAWL, ASSEMBLY	B6131255				A5135052		
46	SLIDE, FEED, BELT, ASSEMBLY	B6131262				A5135053		
47	SPRING, BEAR, ASSEMBLY	B6131265				A5135057		
48	BLOCK, TRUNNION, ASSEMBLY	B6147093				A5139969		
49	ROD, DRIVING SPRING, ASSEMBLY	B6147222				A5152429		
50	BOLT, ASSEMBLY	B6147299				A5152430		
51	LATCH, ASSEMBLY	B7106949				A5152432		
52	SIGHT, BRACKET, GROUP ASSEMBLY	B7132923				A5152737		
53	POST, FRONT SIGHT, ASSEMBLY	B7162616				A5156881		
54						A5156882		
55						A5156883		
56	PACKING AND MARKING DRAWINGS					A5156884		
57	BOX, PACKING (FOR TWO BMS, CAL 30, M1914 FLEX)	P3-12				A5157374		
58	BOX, PACKING (SPARE BARRELS)	P3-14				A5157434		
59	PACKING INSTRUCTIONS FOR ESSENTIAL					A5159870		
60	EXTRA PARTS	P3-55				A5160461		
61	CLEANING, PRESERVING & PACKAGING					A5160656		
62	FOR SMALL ARMS SPARE PARTS	P3-100				A5162810		
63	BOX, PACKING (FOR ONE BMS, CAL 30, M1914 FLEX)	P3-159				A5170491		

SUPERSEDES 51-84-1A W/C 8-19-48

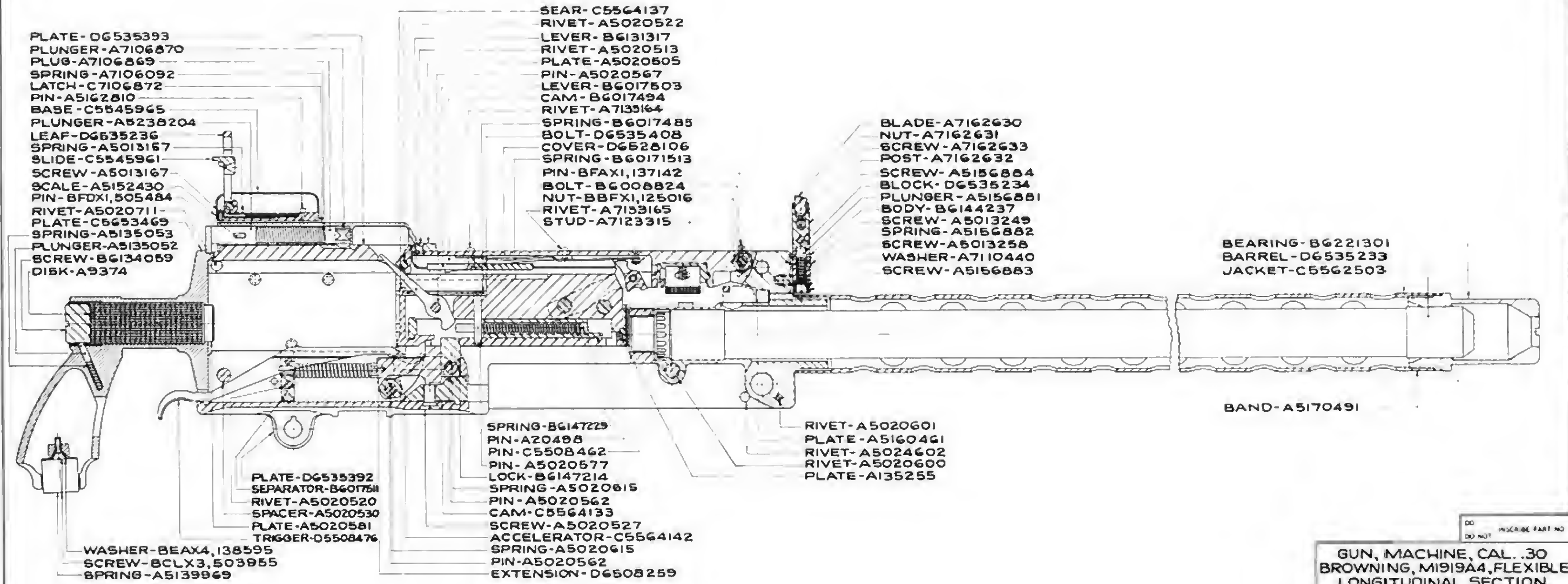
LINE NUMBER	LIST OF SPECIFICATIONS	SPEC NUMBER
1	GUNS, MACHINE, BROWNING, CAL 30, M1914A4 (M1914A5)	52-6-1
2	COMPOUND RUST PREVENTIVE, LIGHT	2-84
3	FIBER, RED, (SHEET)	52-7-11
4	FINISHES, PROTECTIVE, FOR IRON AND STEEL PARTS	57-0-2
5	FORGINGS, LIGHT, DROP AND MISCELLANEOUS	57-105
6	IRON, MALLEABLE, PEARLITIC, CASTINGS	AXS-623
7	MANUFACTURE AND INSPECTION OF SA WEAPONS, & ACC	52-0-1
8	METALS, GENERAL SPECIFICATION FOR INSPECTION OF	OQ-M 151
9	OIL, LUBRICATING, LIGHT	2-27
10	PACKAGING AND PACKING FOR OVERSEAS SHIPMENT,	
11	GENERAL SPECIFICATION	JAN-P-100
12	STANDARD SPECIFICATION FOR MARKING SHIPMENTS	
13	BY CONTRACTORS	100-2
14	STEEL, BARS AND BLANKS (FOR SMALL ARMS GUN BARRELS)	57-107-25
15	STEEL, CARBON AND ALLOY, BARS	EQ-5-671
16	STEEL, CARBON AND ALLOY, PLATE	57-121
17	STEEL, CARBON AND ALLOY; SHEETS AND STRIPS	57-136
18	STEEL, PLATES, SHAPES, SHEETS, STRIPS AND	
19	RECTANGULAR BARS FOR WELDED STRUCTURES	57-114-1
20	STEEL, TOOL, CARBON, ALLOY AND HIGH SPEED	57-108
21	TUBING, ROUND, MECHANICAL AND STRUCTURAL, STEEL,	
22	CARBON AND ALLOY, SEAMLESS, WELDED AND	
23	BRAZED	57-180
24	WIRE, STEEL, SPRING, FOR SMALL ARMS WEAPONS	48-7-1
25		

NOTE

1. NOT REQUIRED WHEN ALTERNATIVE METHOD OF MANUFACTURE OF B6144237 IS USED

2. ALTERNATIVE METHOD OF MANUFACTURE

GUN, MACHINE, CAL. 30 BROWNING, M1914A4 (FLEXIBLE) LIST OF DRAWINGS & SPECIFICATIONS			
SEPTEMBER 30, 1944	CLASS	DESIGN	ISSUE NO.
51	84	1	
REVISIONS		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED FRACTIONAL 1/16 DECIMAL 0.001	
57-13-40			
58-21-49			
59-11-43			
C.F.I.		Z.C.	
DRG PERTAINS TO		SUBMITTED	
		EXAMINED	
		APPROVED BY AUTHORITY	
		DATE	
D		ORDNANCE DEPT. U.S.A.	



SUPERSEDES 51-84-3 WO/C 8-19-48

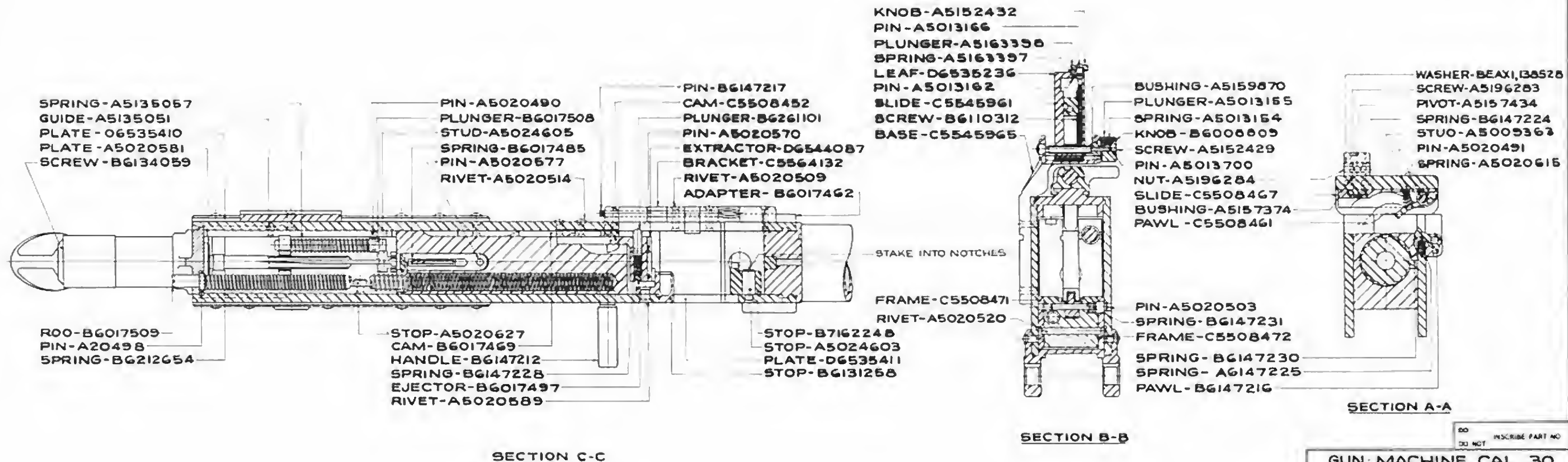


DO NOT INSCRIBE PART NO.			
GUN, MACHINE, CAL. .30 BROWNING, M1919A4, FLEXIBLE LONGITUDINAL SECTION			
SEPTEMBER 30, 1936	CLAS	DIVISION	FILE
REVISIONS	51	84	4
31 10-19-48 32 6-21-49 33 11-15-49	TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMALS 2 FRACTIONS 2 ANGLES 2		
DRG PERTAINS TO 51-84-1 30BAG M1919A4(FLEX)	J J V	Z C	LIT. NUMBER 11/101
SUBMITTED	EXAMINED <i>Walter C. Adams</i> PRO. DES. - 2.0 APPROVED BY THE CHIEF OF ORDNANCE <i>W. Adams</i> ORDNANCE DEPT. U.S.A.		
D	SECURITY ROOM ACCESS DENIED		

SUPERSEDES 51-84-2 WO/C 8-19-48



GUN, MACHINE, CAL. 30 BROWNING, M1919A4 FLEXIBLE RIGHT SIDE VIEW		DO NOT INSCRIBE PART NO			
SEPTEMBER 30, 1936		CLASS	DESIGN	QUANTITY	FILE
REVISIONS 22-0-19-40 25-0-21-40		51	84	2	
		TOLERANCES ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL 2 FRACTIONAL 2 ANGULAR 2			
		MATERIAL CFJ	FINISH ZC	USE SPECIFICATIONS CRIP SPECIFICATIONS	
ORG. PERTAINS TO 51-84-1		IDENTIFIED <i>11/1/02</i>			
		FRAMING <i>Walter Beckman</i> ORG. DEPT. U.S.A. <i>Walter Beckman</i> ORG. DEPT. U.S.A.			
D		ORDNANCE DEPT. U.S.A.			



DO NOT INSCRIBE PART NO.				
GUN, MACHINE, CAL. .30				
BROWNING, M1919A4 FLEXIBLE				
SECTIONAL VIEWS				
SEPTEMBER 30, 1930	CLASS	BY	CHKD	FILE
REVISIONS	51	84	5	
19 8-13-48				
20 6-21-49				
21 11-15-49				
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED				
DECIMAL 1 —				
FRACTIONAL 2 —				
ANGULAR 2 —				
DESIGNED BY	ENGINEER	CHKD	FILE	
PJR	ZC			
SUBMITTED				
DRG PERTAINS TO				
51-84-1				
EXAMINED				
Walter Anderson				
APPROVED BY DESIG. OF THE CHIEF OF ORDNANCE				
ORD. DEPT. U.S.A.				
ORDNANCE DEPT. U.S.A.				

A 5020520

APRIL 4, 1927

REVISIONS

12 5-10-48

DRG. PERTAINS TO

D5509182

.30 BMG
 M 17A1 (WC)
 M 19A4 (FXD)
 M 19A4 (FLEX)
 M 19A5 (FXD)
 M 19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED

DECIMAL : .005

FRACTIONAL : —

ANGULAR : 5°

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.S.C. *L.S.C.*

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.W. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

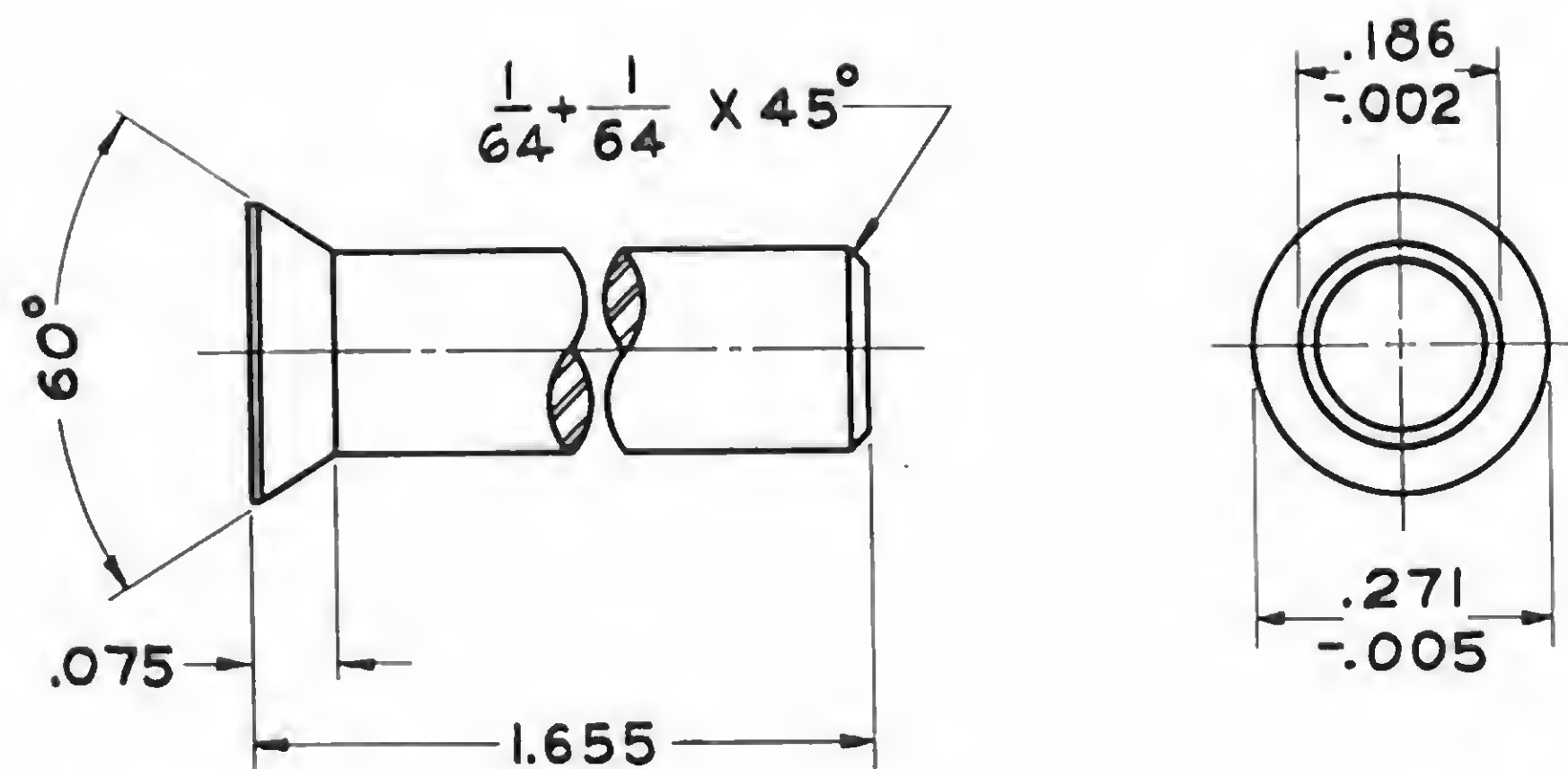
SCL.

T. S.

BR.

EL. 2

ROCK



RIVET
STEEL FS X1335
FINISH 125/

(5020520)

WAS A 20520

SCALE $\frac{4}{1}$

A

5020520

A 5020567

JUNE 1, 1931

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

REVISIONS

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

C45-52

12 5-10-48

DRG. PERTAINS TO

51-114-4

.30 BMG
M19A5(FXD)

51-125-4

.30 BMG
M19A6

51-83-4

.30 BMG
M19A4(FXD)

51-84-4

.30 BMG
M19A4(FLEX)

51-10-45

.30 BMG
M1A1(WC)INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR \pm —

DRAFTSMAN

W.C.O.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKED

L.S.C.

O.D.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

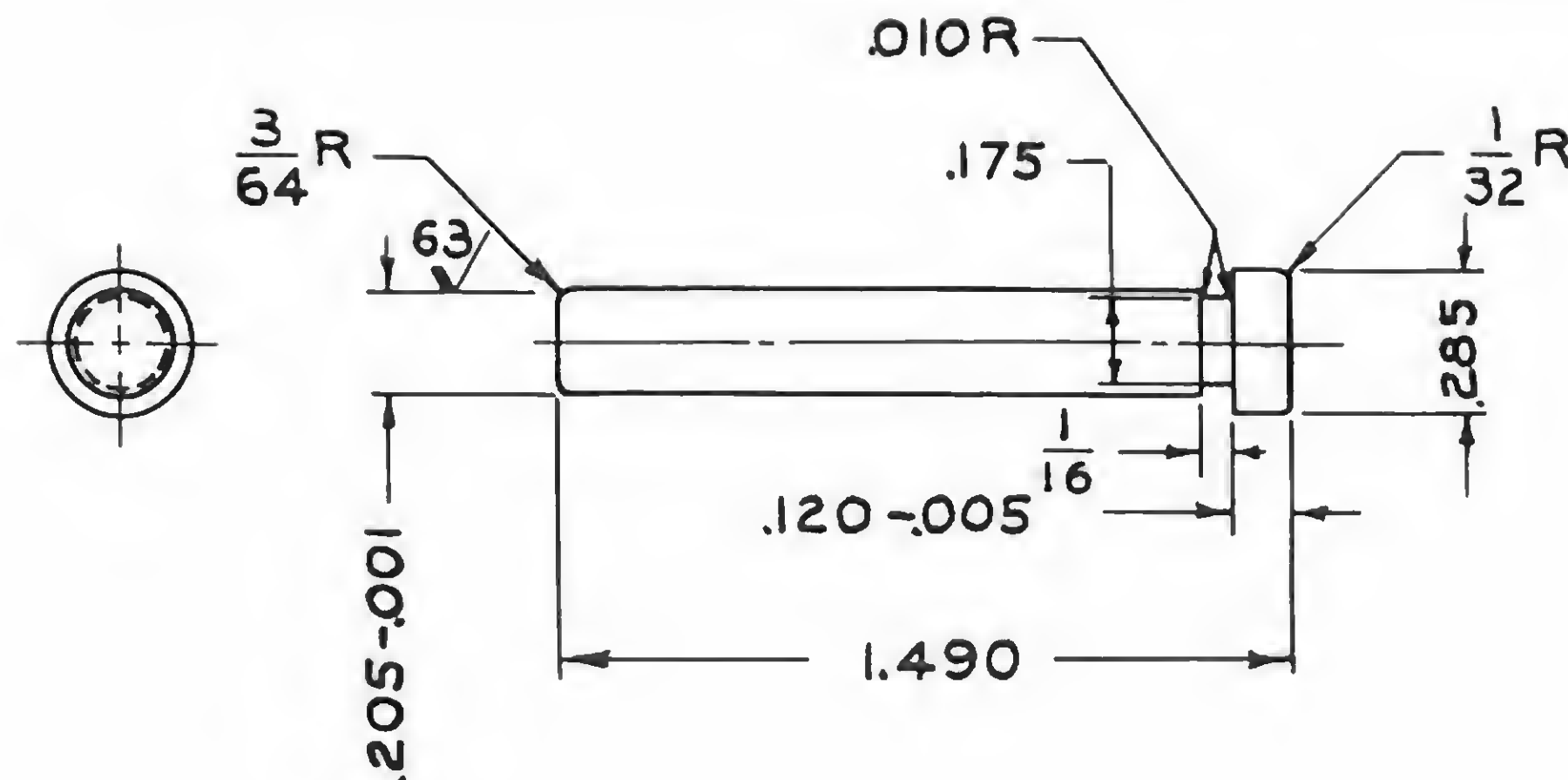
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**PIN, COCKING LEVER****STEEL FS 4140**FINISH $125/100-501$, OTHER SURFACES, AS SPECIFIED

(5020567)

WAS A20567

SCALE $\frac{2}{1}$

A

5020567

A 5135057

JUNE 1, 1931

REVISIONS

18 5-10-48

DRG. PERTAINS TO

51-83-5

.30 BMG
M19A4 (FXD)

51-84-5

.30 BMG
M19A4 (FLEX)

51-114-5

.30 BMG
M19A5 (FXD)

51-125-5

.30 BMG
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL —
FRACTIONAL —
ANGULAR —

DRAFTSMAN W.L.M.	TRACER M.C.	L'D'G DRAFTSMAN
CHECKED E.W.R.		CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. Schuman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT & FINAL FINISH

DRAW AT 450° F
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350° F

PHYSICAL PROPERTIES

Y. P.		RED.		SCL.	
T. S.		BR.			
EL 2		ROCK			

DIAMETER OF WIRE	.047
TOTAL NUMBER OF COILS	24
MINIMUM INSIDE DIAMETER, FREE	.290
OUTSIDE DIAMETER, FREE	.387±.005
MAX. OUTSIDE DIA AT MIN. OPERATING HEIGHT	.402
FREE LENGTH	3.56 APPROX
TYPE OF ENDS	SQ ENDS GROUND
WOUND	R.H.
ASSEMBLED HEIGHT	1.85
LOAD AT ASSEMBLED HEIGHT	13.9±1LB
MINIMUM OPERATING HEIGHT	1.222
LOAD AT MINIMUM OPERATING HEIGHT	19±1LB
LB PER INCH OF SPRING DEFLECTION	8.1 APPROX
SPRING FUNCTIONS OVER ROD	.275
CALCULATED MAXIMUM SOLID HEIGHT	1.128

NOTE: CAUTION: DO NOT COMPRESS SOLID.

0.5% OF SPRINGS WILL BE FATIGUE TESTED
BETWEEN ASSEMBLED HEIGHT AND MINIMUM
OPERATING HEIGHT FOR 50,000 CYCLES. THE
LOAD AT ASSEMBLED HEIGHT, AFTER TESTING,
SHOULD NOT BE LESS THAN 12.5 LB

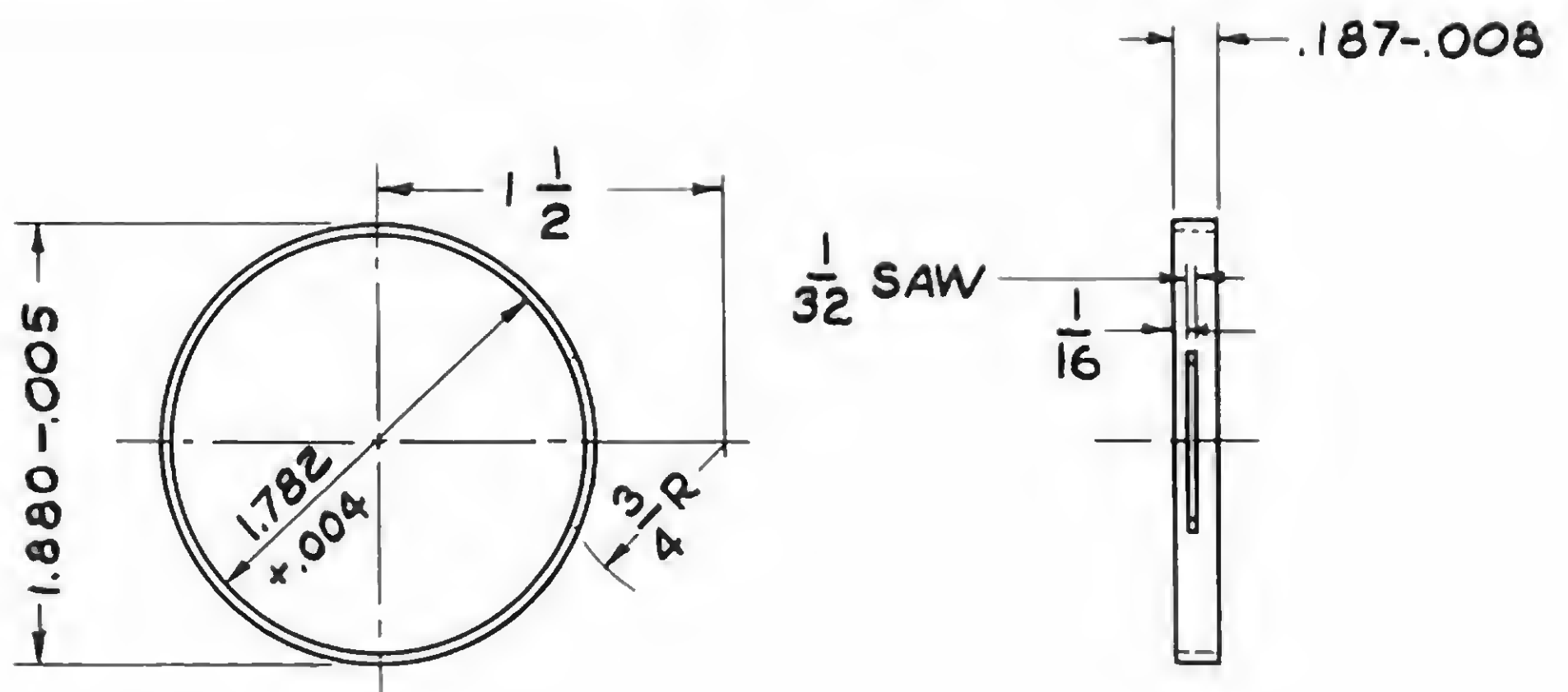
SPRING, BARREL, PLUNGER

SPRING STEEL WIRE WD1085 SPECIAL-CLASS A

5135057

WAS A135057

A 5135057

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5170491 FEB. 17, 1939							
TYPE II FINISH, CLASS B		Y. P.		RED.		SCL.							
		T. S.		BR.									
		EL. 2		ROCK									
		REVISIONS											
		8	5-10-48										
<p>NOTE: BREAK ALL SHARP EDGES .010</p> <p>BAND, LOCK, FRONT BARREL BEARING (5170491) <u>SEAMLESS STEEL TUBING, WDX 1020</u> FINISH 125/4 R</p> <p>SCALE 1/1</p> <p>WAS A 170491</p> <p>A 5170491</p>		DRG. PERTAINS TO											
		51-83-4	.30 BMG M19A4 (FXD)										
		51-84-4	.30 BMG M19A4 (FLEX)										
		51-114-4	.30 BMG M19A5 (FXD)										
		51-125-4	.30 BMG M19A6										
<p>INScribe PART NO. DO NOT</p> <p>TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± .005 FRACTIONAL ± 1/64 ANGULAR ± —</p> <table><tr><td>DRAFTSMAN A.W.R.</td><td>TRACER O.K.</td><td>L'D'G DRAFTSMAN</td></tr><tr><td>CHECKER LSC EWR</td><td></td><td>CHIEF DRAFTSMAN</td></tr></table> <p>SUBMITTED: <i>A.H. Roe</i> ORD. DEPT., U. S. A.</p> <p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter G. ...</i> ORD. DEPT., U. S. A.</p> <p>ORDNANCE DEPT., U. S. A.</p>		DRAFTSMAN A.W.R.	TRACER O.K.	L'D'G DRAFTSMAN	CHECKER LSC EWR		CHIEF DRAFTSMAN						
		DRAFTSMAN A.W.R.	TRACER O.K.	L'D'G DRAFTSMAN									
		CHECKER LSC EWR		CHIEF DRAFTSMAN									

A 6147225

FEBRUARY 1, 1938

REVISIONS

10 5-10-48

DRG. PERTAINS TO

51-10-45

.30 BMG
M17A1(WC)

51-83-5

.30 BMG
M19A4(FXD)

51-84-5

.30 BMG
M19A4(FLEX)

51-114-5

.30 BMG
M19A4(FXD)

51-125-5

.30 BMG
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± —
FRACTIONAL ± —
ANGULAR ± —

DRAFTSMAN
W.L.M.

TRACER
M. C.

L'D'G DRAFTSMAN

CHECKER
W.H. [Signature]

0.0.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT & FINAL FINISH

DRAW AT 450°F.
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F.

PHYSICAL PROPERTIES

Y. P.		RED.		SCL.	
T. S.		BR.			
EL. 2		ROCK			

DIAMETER OF WIRE .023
TOTAL NUMBER OF COILS (APPROX) 13
MINIMUM INSIDE DIAMETER, FREE .091
MAXIMUM OUTSIDE DIAMETER (SOLID) .15
FREE LENGTH (APPROX) .65
TYPE OF ENDS SQ & GD
WOUND R.H. OR L.H.
ASSEMBLED HEIGHT .500
LOAD AT ASSEMBLED HEIGHT 3.25 ± .50 LB
MINIMUM OPERATING HEIGHT .360
LOAD AT MINIMUM OPERATING HEIGHT 6.25 ± .50 LB
MAXIMUM SOLID HEIGHT .310

NOTE:

.5% OF SPRINGS WILL BE FATIGUE TESTED
BETWEEN ASSEMBLED HEIGHT AND MINIMUM
OPERATING HEIGHT FOR 25,000 CYCLES. THE
LOAD AT ASSEMBLED HEIGHT, AFTER TESTING,
SHOULD NOT BE LESS THAN 2. LB

SPRING, BELT HOLDING PAWL
SPRING STEEL WIRE WD1085 SPECIAL - CLASS A

6147225

WAS B147225

A 6147225

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	C45-52
SCL.	

APRIL 4, 1927

REVISIONS

9 5-10-48

DRG. PERTAINS TO

B6147222 .30 BMG
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 5^\circ$

DRAFTSMAN	TRACER	C.D.G. DRAFTSMAN
M. & J.	E. B.	
CHECKED		CHIEF DRAFTSMAN

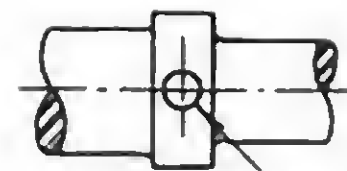
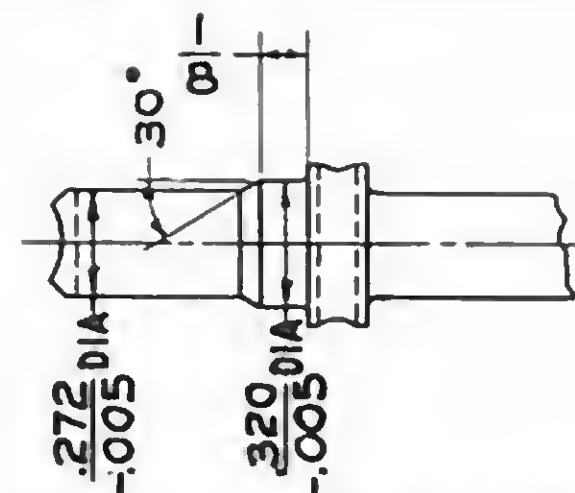
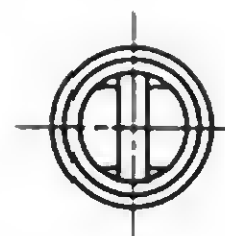
SUBMITTED:

A. H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

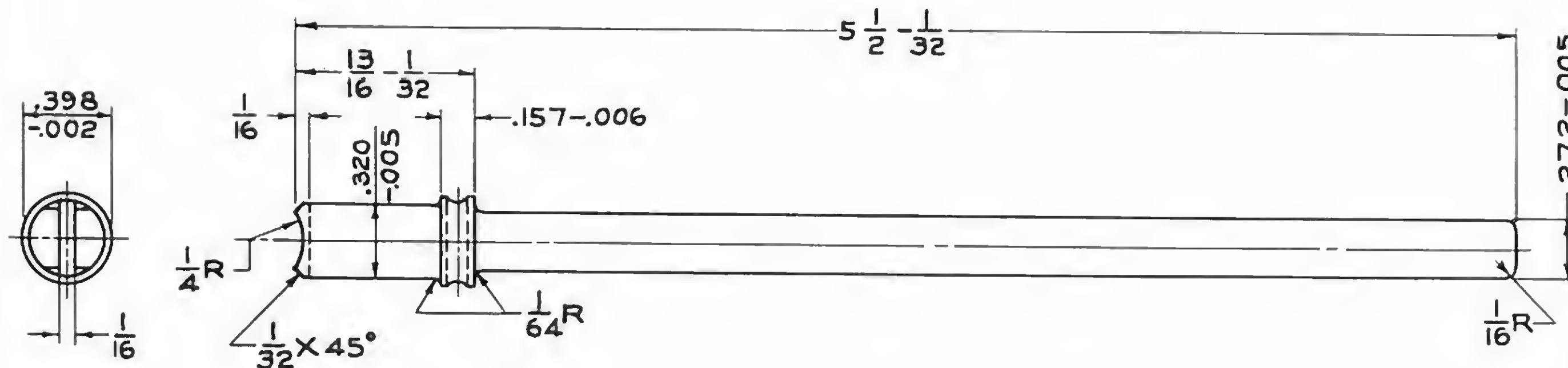
Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT U. S. A.



.093+.001

VIEW SHOWING ALTERNATIVE
METHOD OF MANUFACTURE



ROD, DRIVING SPRING

STEEL FS 1095

FINISH 125/

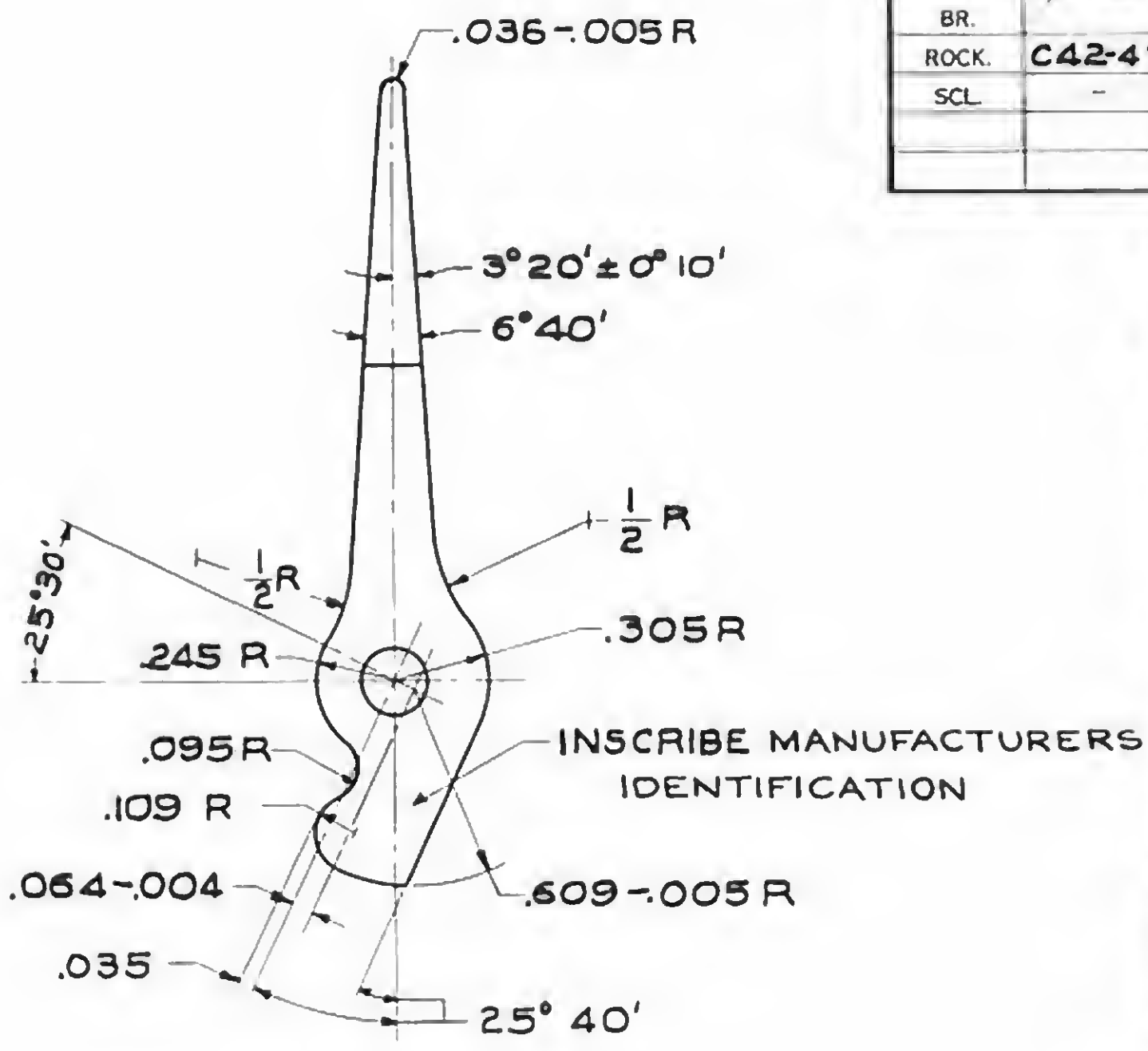
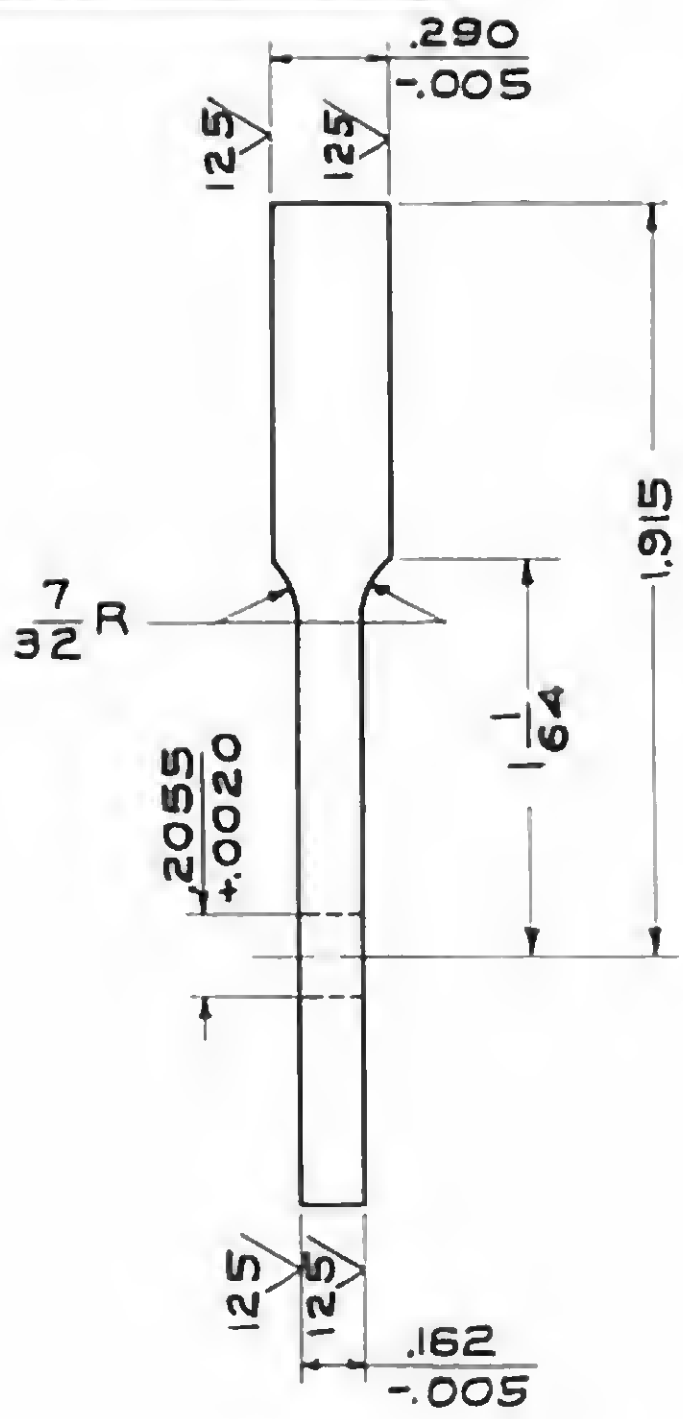
(6017509

WAS B17509

SCALE $\frac{2}{1}$ B 6017509

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B



LEVER, COCKING
STEEL FS X4340
FINISH 63/ ∇ , OTHER SURFACES, AS SPECIFIED

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	C42-47
SCL	-

JUNE 1, 1931			
REVISIONS			
19	5-10-48		

DRG. PERTAINS TO	
51-10-46	30 BMG M17A1 (WC)
51-83-4	30 BMG M19A4 (FXD)
51-84-4	30 BMG M19A4 (FLEX)
51-114-4	30 BMG M19A5 (FXD)
51-125-4	30 BMG M19A6

DO INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± .005
FRACTIONAL ± 1/64
ANGULAR ± 0°30'

DRAFTSMAN C.S.S.	TRACER E.R.G.	L'DG DRAFTSMAN
CHECKER V.B.C.	G.D.	CHIEF DRAFTSMAN

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SCALE 2/1 B WAS B131317
6131317

B6131317

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	C29-38
SCL.	-

FEBRUARY 1, 1938

REVISIONS

10	5-10-48		

DRG. PERTAINS TO

51-10-45	.30 BMG M17A1 (WC)
51-83-5	.30 BMG M19A4 (FXD)
51-84-8	.30 BMG M19A4 (FLEX)
51-125-8	.30 BMG M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 5°

DRAFTSMAN	TRACER	L'DG DRAFTSMAN
W.C.O.	O.K.	
CHECKER		CHIEF DRAFTSMAN
<i>W.C.O.</i>		

SUBMITTED:

A.H. Roe

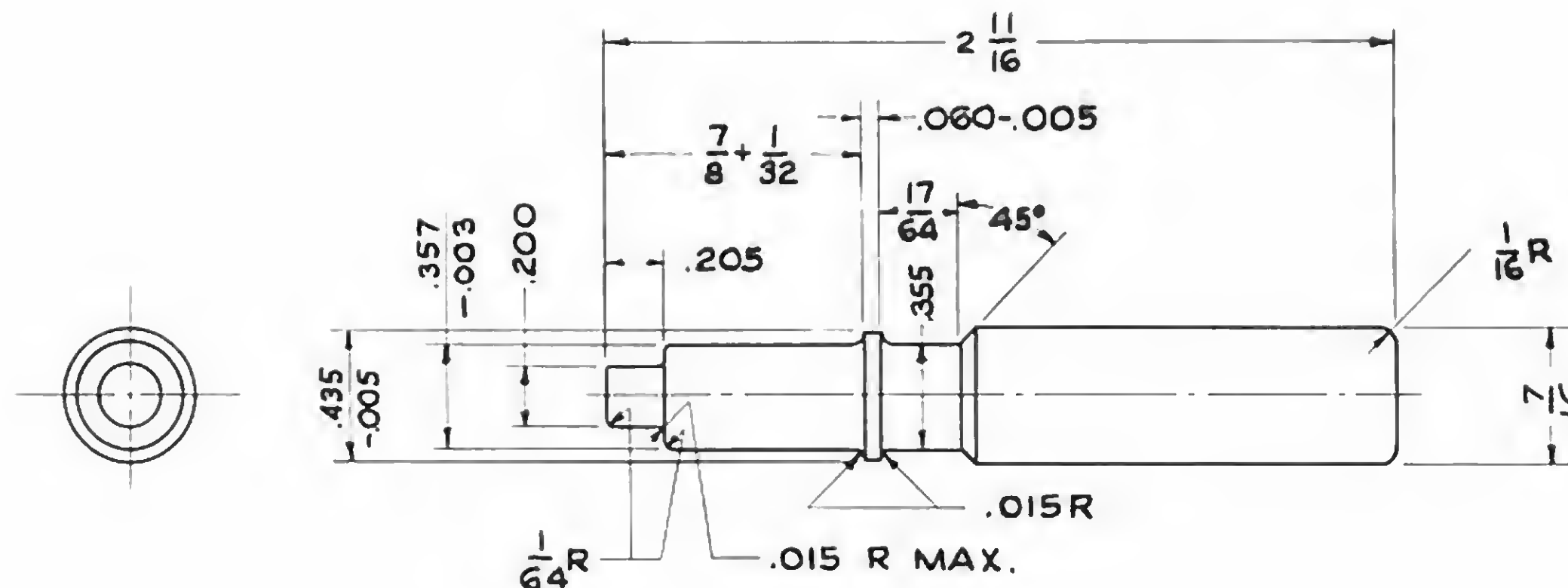
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



HANDLE BOLT (6147212)
STEEL F S 1045
FINISH 125/

SCALE $\frac{2}{1}$

WAS B147212

B 6147212

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.
T. S.
EL 2
RED
BR.
ROCK.
SCL

REVISIONS

135-10-48

DRG. PERTAINS TO

51-10-45	30 BMG M17A1 (WC)
51-83-4	30 BMG M19A4 (FXD)
51-84-4	30 BMG M19A4 (FLEX)
51-114-4	30 BMG M19A5 (FXD)
51-125-4	30 BMG M19A6

DO INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR - 1°

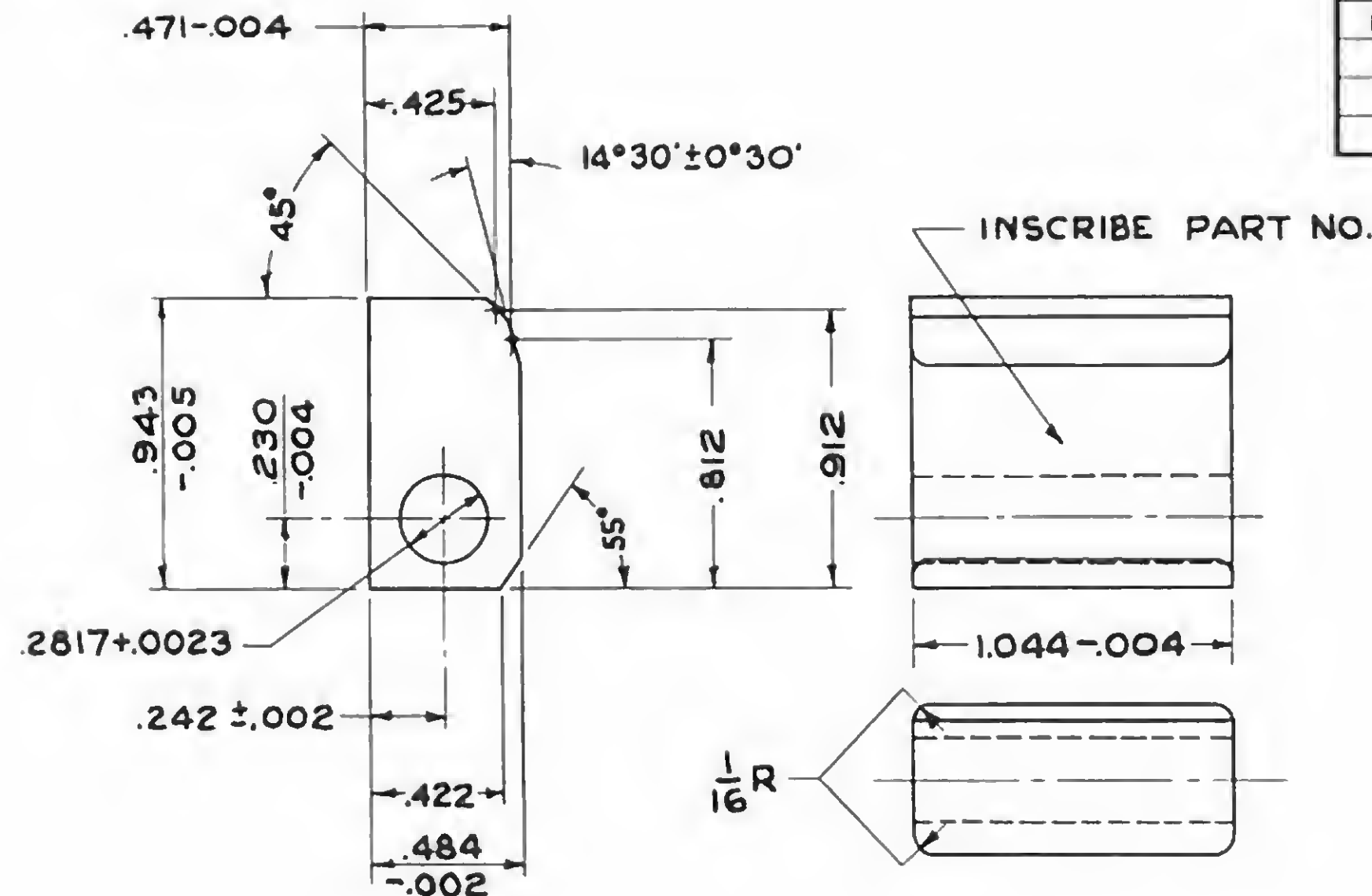
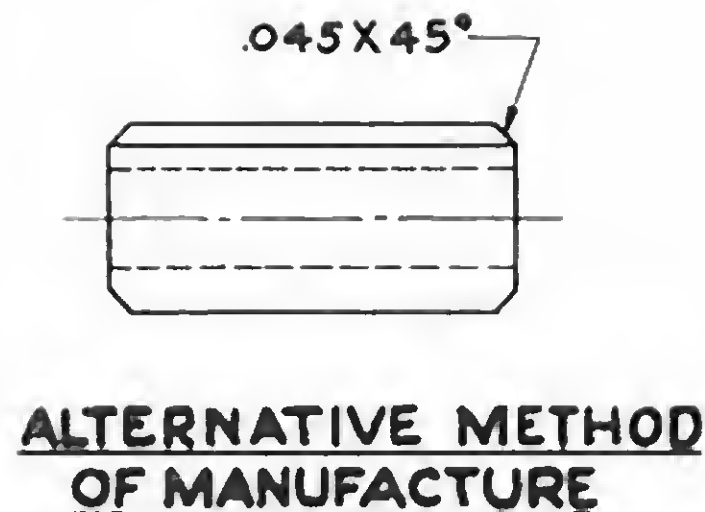
CRAFTSMAN W.C.O.	TRACER O.K.	L.D.C. DRAFTSMAN
CHECKER H.W.J.	O.D.	CHIEF DRAFTSMAN

SUBMITTED:
A.H. Roe
ORO. DEPT. - U. S. A

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:-
Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

86147214



LOCK, BRECH
STEEL FSX 4340
FINISH 63 ✓

6147214

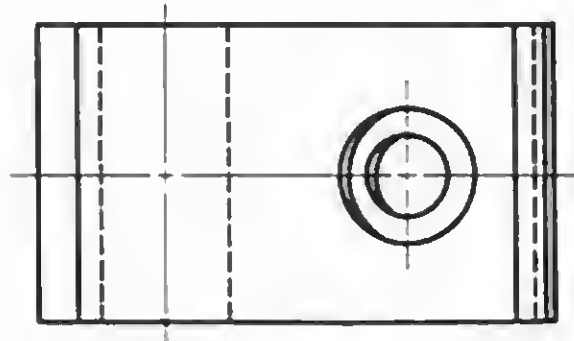
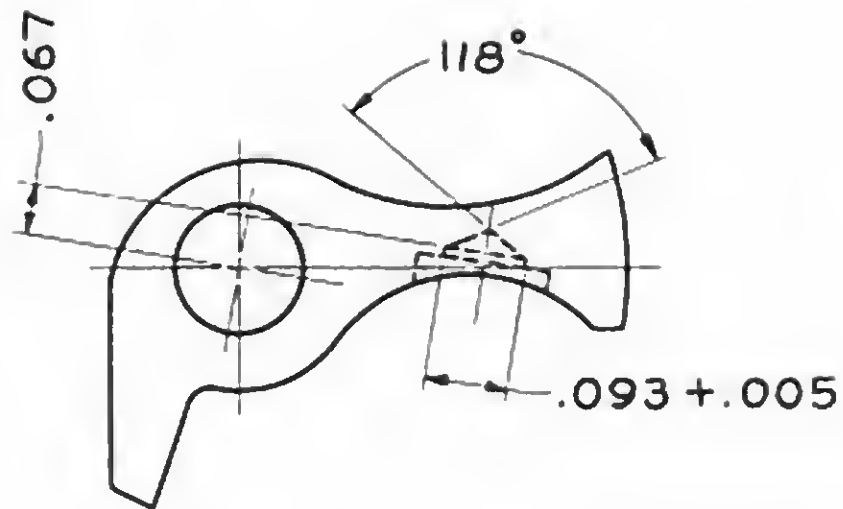
SCALE 2
1

WAS B 147214

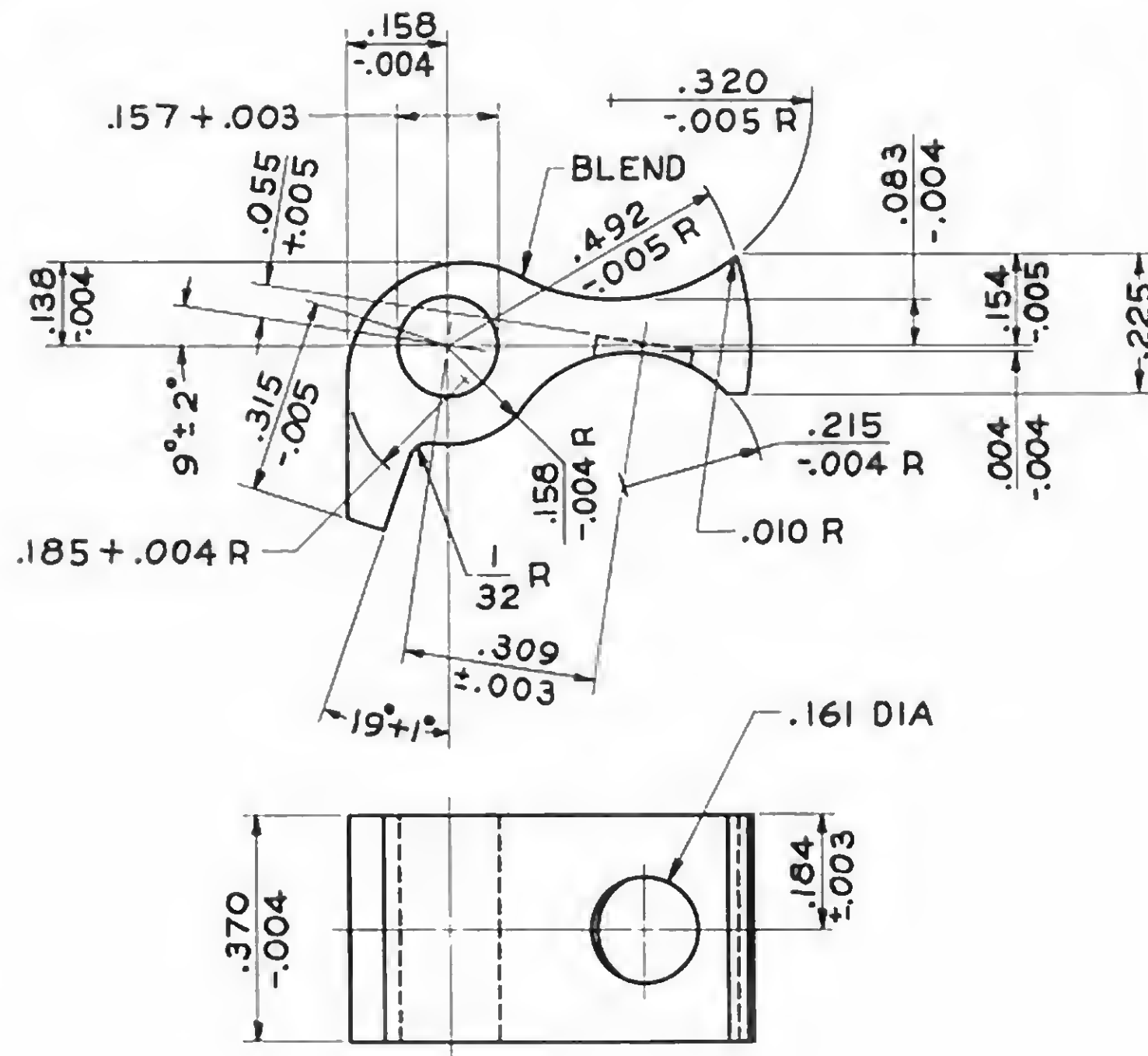
B	6147214
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SCALE 2
1

HEAT TREAT
TYPE II FINISH, CLASS B



ALTERNATIVE METHOD OF MANUFACTURE



PAWL, HOLDING, BELT
STEEL FS 4140
FINISH 125✓

6147216

WAS B147216

SCALE $\frac{4}{1}$

B 6147216

PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK
SCL.

C45-52

FEBRUARY 1, 1938

REVISIONS

13 5-10-48

DRG. PERTAINS TO

51-10-45	30 BMG M17A1 (WC)
51-83-5	30 BMG M19A4 (FXD)
51-84-5	30 BMG M19A4 (FLEX)
51-114-5	30 BMG M19A5 (FXD)
51-125-5	30 BMG M19A6

DO NOT INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 1°

DRAFTSMAN W.C.O.	TRACER L.R.E.	LOG DRAFTSMAN L.R.E.
----------------------------	-------------------------	--------------------------------

CHECKER		CHIEF DRAFTSMAN
---------	--	-----------------

SUBMITTED:

A.H. ROE

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:-

ORD. DEPT., U. S. A.

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

B6147216

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

FEB. 1, 1938

REVISIONS

4 5-10-48

DRG. PERTAINS TO

51-10-1 30 BMG
M 17A1 (WC)
51-83-1 30 BMG
M 19A4 (FXD)
51-84-1 30 BMG
M 19A4 (FLEX)
51-114-1 30 BMG
M 19A5 (FXD)
51-125-1 30 BMG
M 19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± —
FRACTIONAL ± —
ANGULAR ± —

CHAFFMAN H.S.	TRACER E.R.G.	L.D.C. DRAFTSMAN
CHECKER L.S.	C.D.	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

PIN-A20498

ROD-B6017509

ROD, DRIVING SPRING, ASSEMBLY

6147222

WAS B147222

B 6147222

B6147222

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A72-76
SCL	

FEBRUARY 1, 1938

REVISIONS

11	5-10-48		

DRG. PERTAINS TO

51-10-45	.30 BMG M17A1 (WC)
51-83-5	.30 BMG M19A4 (FXD)
51-84-5	.30 BMG M19A4 (FLEX)
51-114-5	.30 BMG M19A5 (FXD)
51-125-5	.30 BMG M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 2^\circ$

DRAFTSMAN T.J.C.	TRACER A.V.C.	L.D.'S DRAFTSMAN
CHECKER V.C.		CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

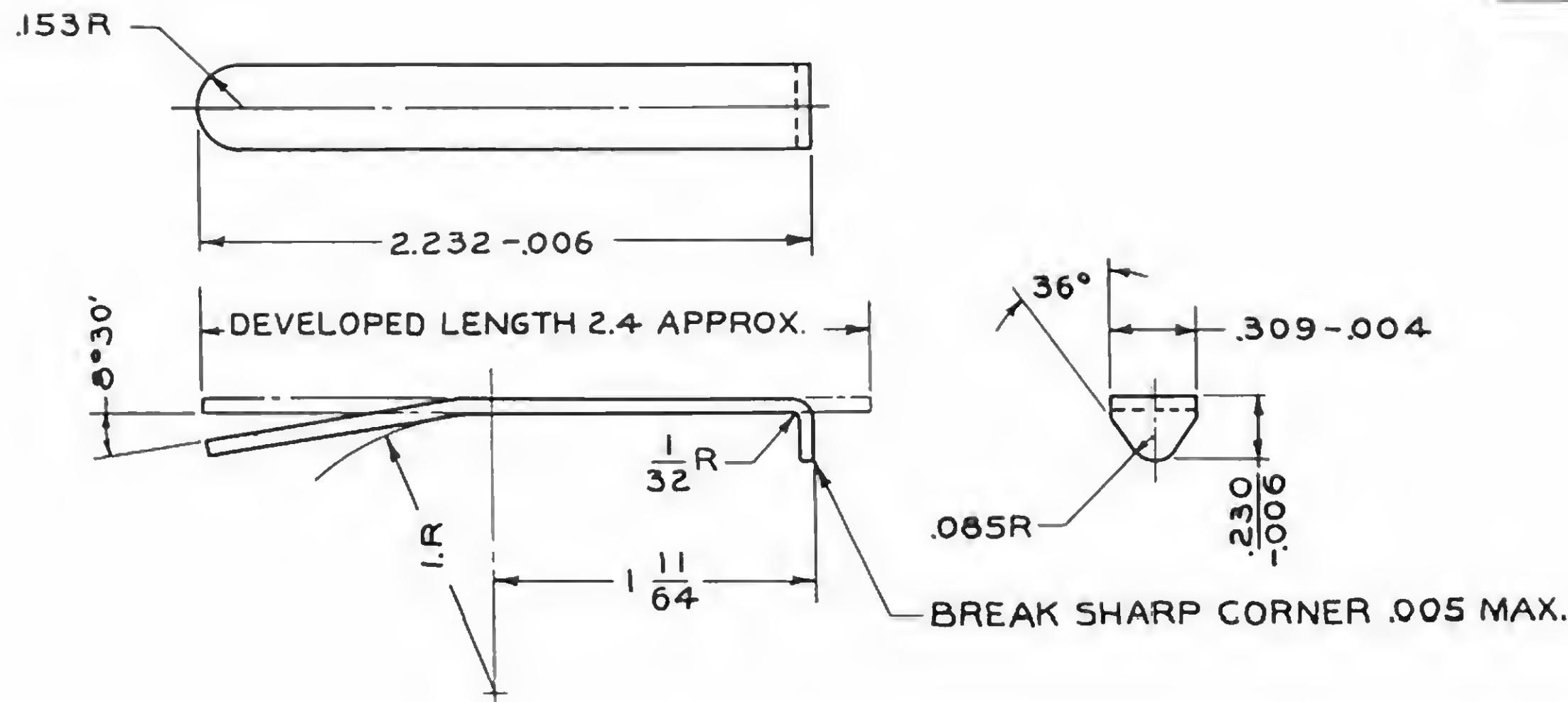
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:-

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



SPRING, LOCKING, BARREL

SPRING STEEL WD1095
NO. 18 (.0478 U.S. GAGE) THICK

6147230

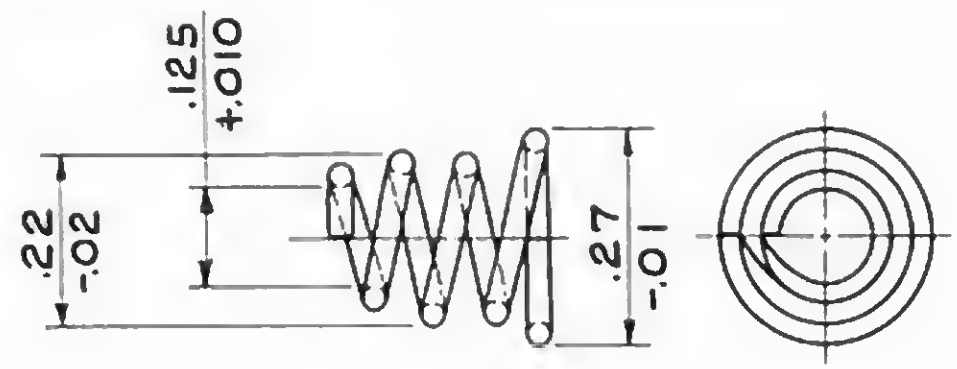
SCALE $\frac{2}{1}$

WAS B147230

B 6147230

B6147230

HEAT TREATMENT AND FINAL FINISH
DRAW AT 450°F
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F



DIAMETER OF WIRE .031
TOTAL NUMBER OF COILS 4
OUTSIDE DIAMETER, FREE .22-.02
MAX. OUTSIDE DIA AT MIN. OPERATING HEIGHT .270
FREE LENGTH .28-.02
TYPE OF ENDS AS SHOWN
WOUND L.H.
MEAN ASSEMBLED HEIGHT .242
MIN. LOAD AT MEAN ASSEMBLED HEIGHT 2. LB
MINIMUM OPERATING HEIGHT .131
MIN. LOAD AT MIN. OPERATING HEIGHT 7.85 LB
LB PER INCH OF SPRING DEFLECTION 52.6
SPRING FUNCTIONS IN HOLE (LARGE END) .252
SPRING FUNCTIONS OVER ROD (SMALL END) .135

CAUTION: DO NOT COMPRESS SOLID.

SPRING, TRIGGER PIN
SPRING STEEL WIRE WD1085 SPECIAL-CLASS A

6147231

SCALE 4/1

WAS B147231
B 6147231

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
BR.	
ROCK	
SCL	

FEBRUARY 1, 1938			
REVISIONS			
9	5-10-48		

DRG. PERTAINS TO	
51-10-45	.30 BMG M17A1(WC)
51-83-5	.30 BMG M19A4(FXD)
51-84-5	.30 BMG M19A4(FLEX)
51-114-5	.30 BMG M19A5(FXD)
51-125-5	.30 BMG M19A6

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± —
FRACTIONAL ± —
ANGULAR ± —

DRAFTSMAN W.L.M.	TRACER M.C.	L'D'G DRAFTSMAN
CHECKER		CHIEF DRAFTSMAN

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6147231

HEAT TREATMENT AND FINAL FINISH
DRAW AT 450°F.
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F.

DIAMETER OF WIRE .045
TOTAL NUMBER OF COILS (ADJUST TO OBTAIN LOAD) 103 APPROX
MINIMUM INSIDE DIAMETER, FREE .300
OUTSIDE DIAMETER, FREE .395 ± .004
MAX. OUTSIDE DIA AT MIN. OPERATING HEIGHT .404
FREE LENGTH 15.875 ± .25
TYPE OF ENDS ENDS CLOSED AND GROUND SQUARE
WOUND R.H. OR L.H.
MEAN ASSEMBLED HEIGHT 9.875
LOAD AT MEAN ASSEMBLED HEIGHT 8.2 LB ± .7 LB
MINIMUM OPERATING HEIGHT 5.311
LOAD AT MINIMUM OPERATING HEIGHT 14.3 LB ± 1 LB
LB PER INCH OF SPRING DEFLECTION 1.35
SPRING FUNCTIONS IN HOLE .408
SPRING FUNCTIONS OVER ROD .272
SOLID HEIGHT NOT TO EXCEED 4.9

CAUTION: DO NOT COMPRESS SOLID
NOTE:
0.5% OF SPRINGS WILL BE FATIGUE TESTED
BETWEEN ASSEMBLED HEIGHT AND MINIMUM
OPERATING HEIGHT FOR 50,000 CYCLES. THE
LOAD AT ASSEMBLED HEIGHT, AFTER TESTING,
SHOULD NOT BE LESS THAN 6.5 LB

SPRING, DRIVING
SPRING STEEL WIRE WD1085 SPECIAL - CLASS A 6212654

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED.	
BR.	
ROCK	
SCL	

JANUARY 8, 1942			
REVISIONS			
8	5-10-48		

DRG. PERTAINS TO	
51-10-45	.30 BMG M17A1 (WC)
51-83-5	.30 BMG M19A4 (FXD)
51-84-5	.30 BMG M19A4 (FLEX)
51-114-5	.30 BMG M19A3 (FXD)
51-125-5	.30 BMG M19A6

TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± - FRACTIONAL ± - ANGULAR ± -		
DRAFTSMAN M.D.I.	TRACER M.C.	L'D'S DRAFTSMAN
CHECKER <i>[Signature]</i>		CHIEF DRAFTSMAN

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter A. ...
ORD. DEPT., U. S. A.
ORDNANCE DEPT., U. S. A.

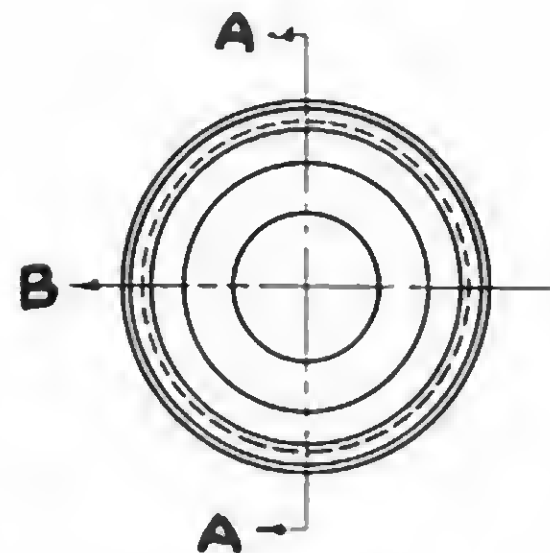
WAS B212654
B 6212654

B6212654

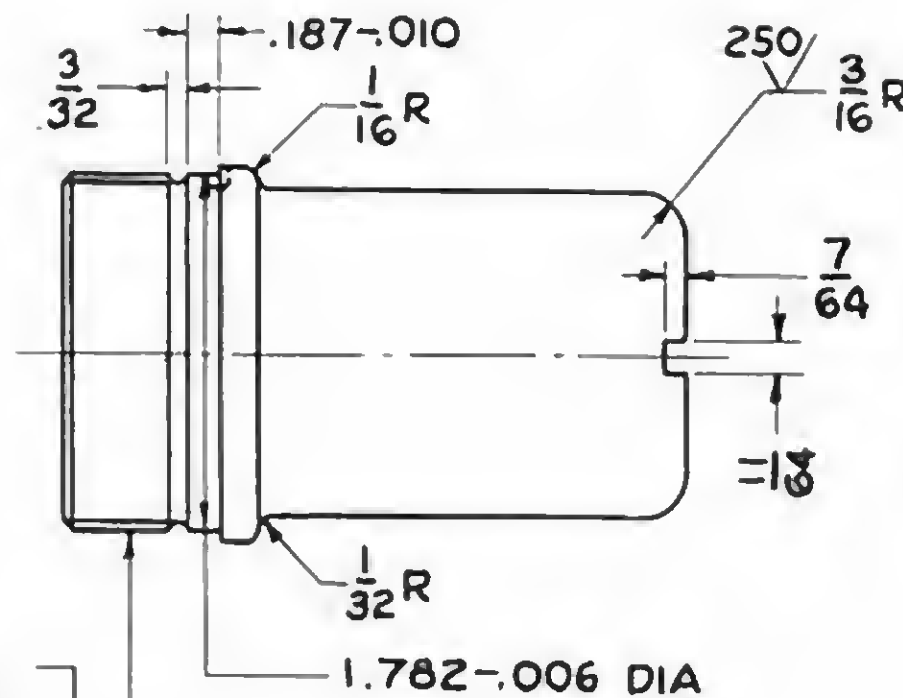
TYPE II FINISH, CLASS B



SCALE $\frac{2}{1}$

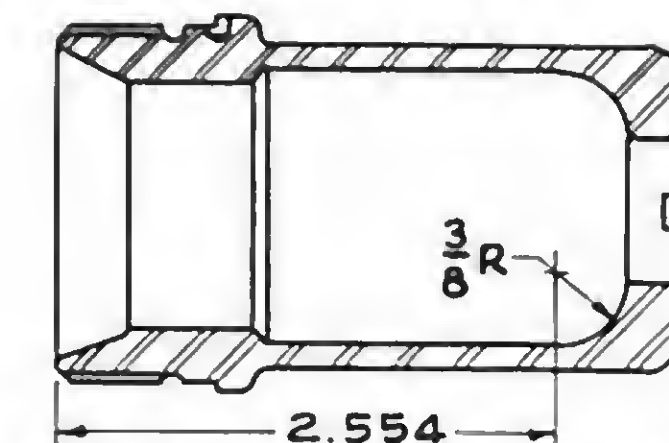


1.78-22NS-3	MAJOR DIA	1.7800-.0100
	PITCH DIA	1.7505-.0044
	MINOR DIA	1.7242 MAX.

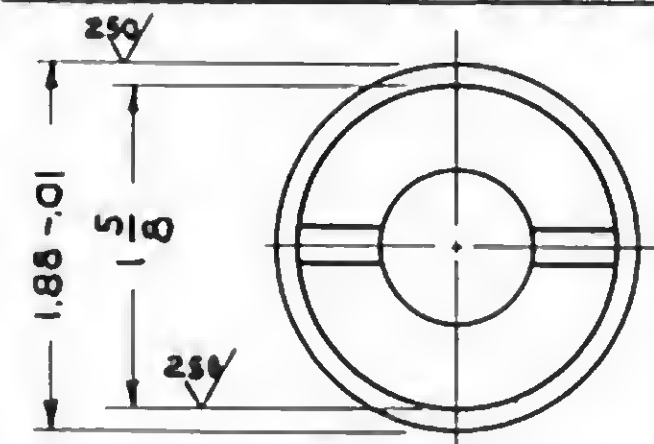


BEARING, BARREL, FRONT
STEEL FSX 1335

FINISH ¹²⁵/_✓, OTHER SURFACES AS SPECIFIED



ALTERNATIVE DESIGN



PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK
SCL

JULY 18, 1942

REVISIONS

8 5-10-48

DRG. PERTAINS TO

51-83-4	308BMG M19A4 (FXD)
51-84-4	308BMG M19A4 (FLEX)
51-114-4	308BMG M19A5 (FXD)

DO NOT INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± .010
FRACTIONAL ± 1/64
ANGULAR ± 1°

DRAFTSMAN R. J. S.	TRACER O. K.	LDG DRAFTSMAN
CHECKER W. J. S.	O. O.	CHIEF DRAFTSMAN

SUBMITTED:

A.H. ROE

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:-

Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SCALE $\frac{1}{1}$

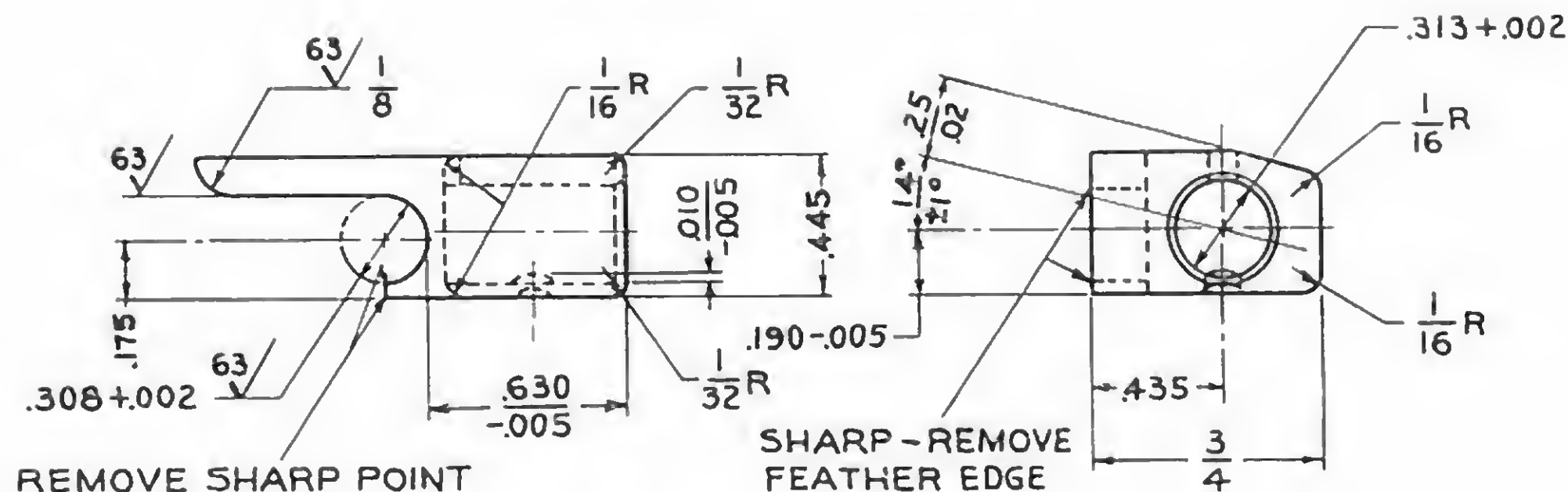
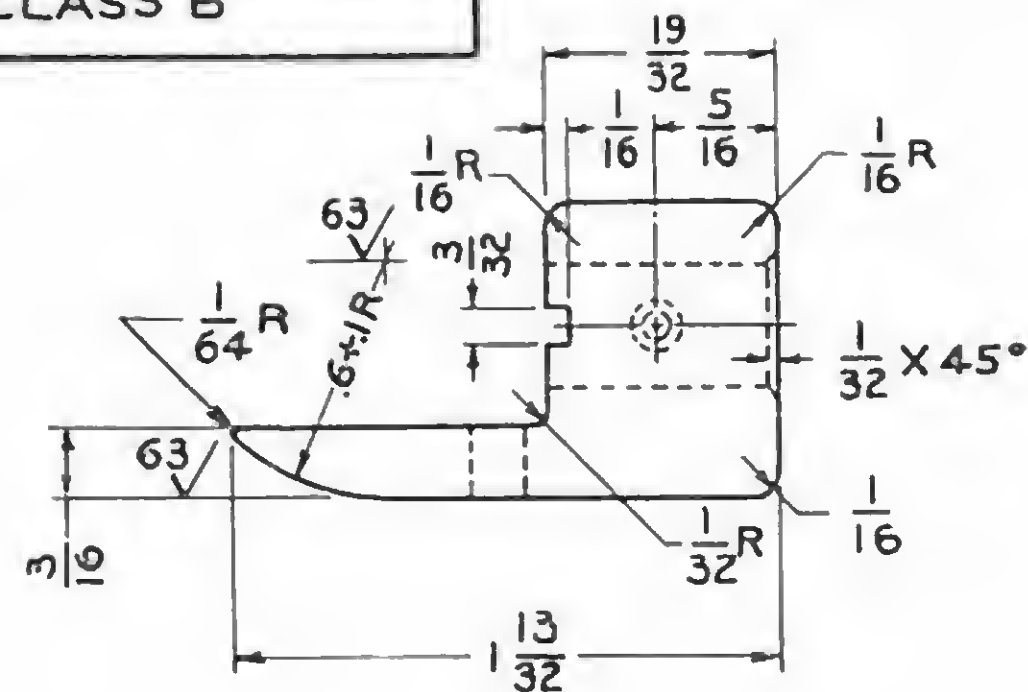
WAS 8221301

B 6221301

B6221301

HEAT TREATMENT AND FINAL FINISH

CASE HARDEN .010 DEEP APPROX
TYPE II FINISH, CLASS B



STOP, SHORT ROUND

STEEL FS1020

7162248

FINISH $\sqrt{125}$, OTHER SURFACES, AS SPECIFIED

PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

MARCH 6, 1946

REVISIONS

1 5-10-48

DRG. PERTAINS TO

51-10-45 .30 BMG
M17A1 (WC)
51-83-5 .30 BMG
M19A4 (FXD)
51-84-5 .30 BMG
M19A4 (FLEX)
51-114-5 .30 BMG
M19A5 (FXD)
51-125-5 .30 BMG
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 5°

DRAWN L.E.K.	TRACED A.V.C.	CHECKED G.D.
DESIGNED G.D.	INSP. G.D.	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES B7162248 W O/C 5-10-48

SCALE $\frac{2}{1}$

B 7162248

B7162248

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS BPHYSICAL
PROPERTIES

FEBRUARY 1, 1938

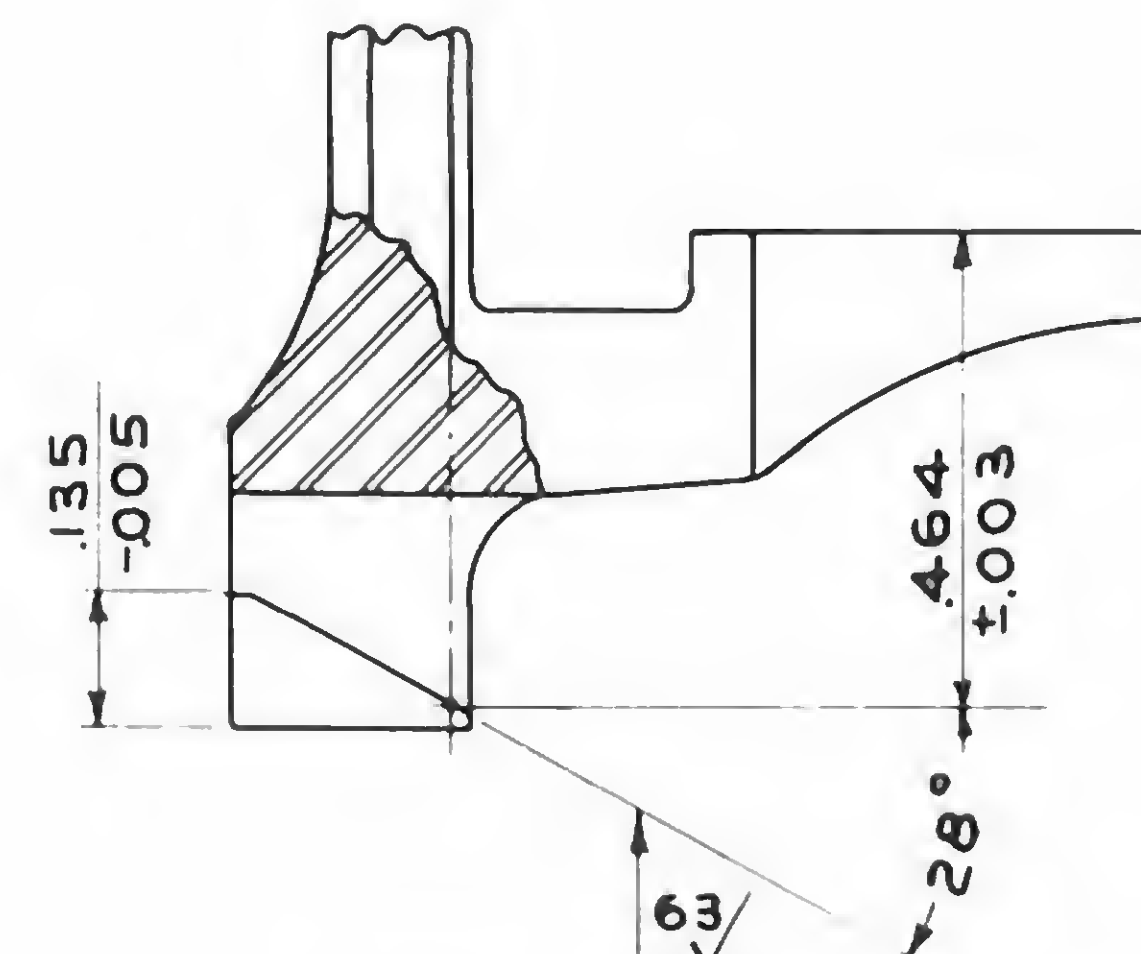
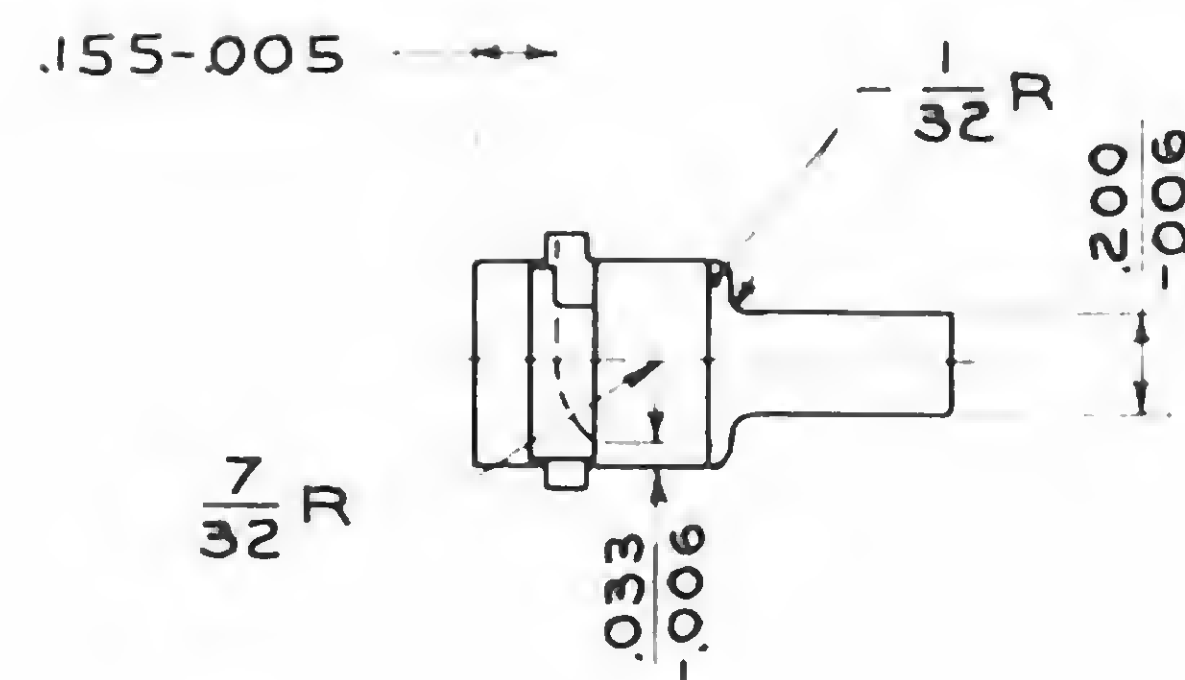
Y. P.
T. S.
EL. 2
RED
BR.
ROCK. C47-52
SCL.

REVISIONS

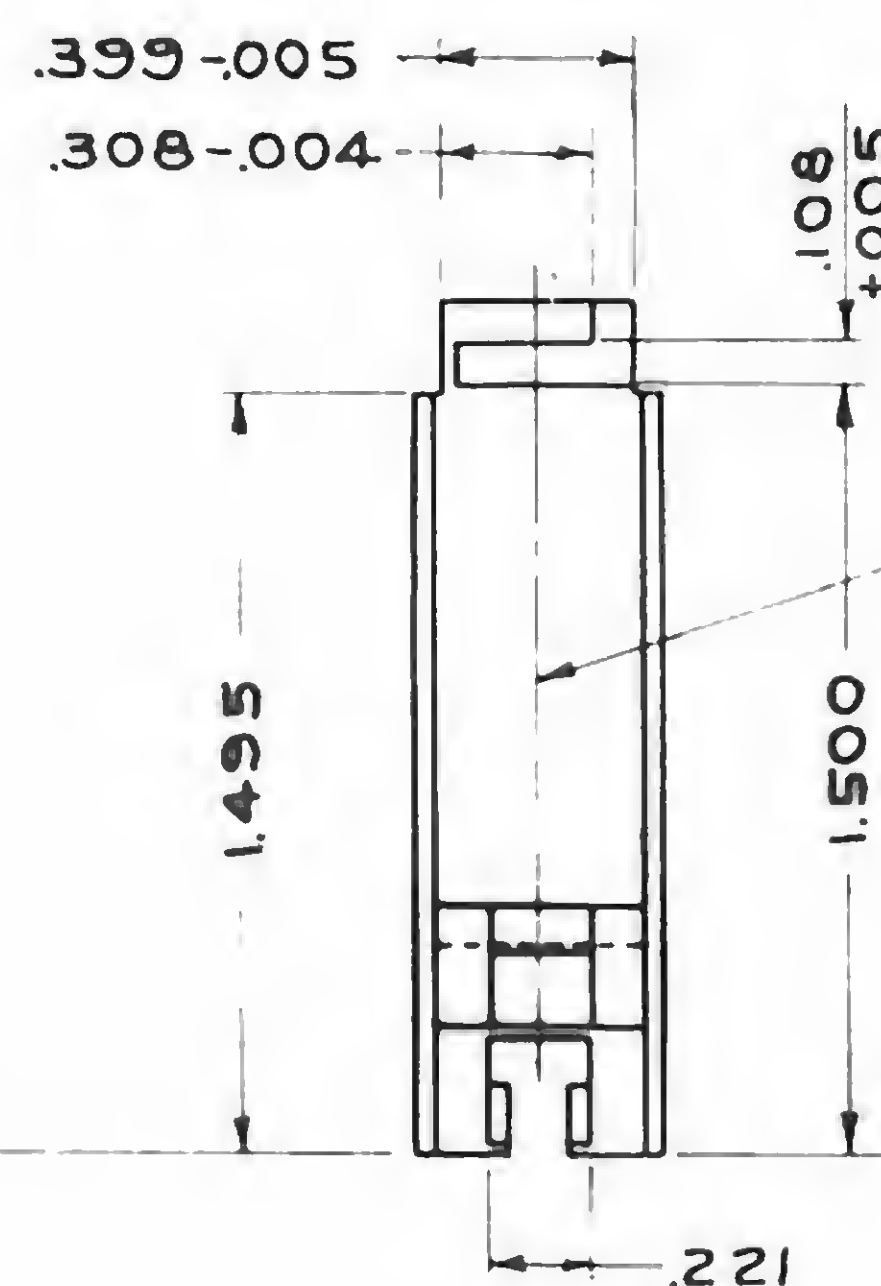
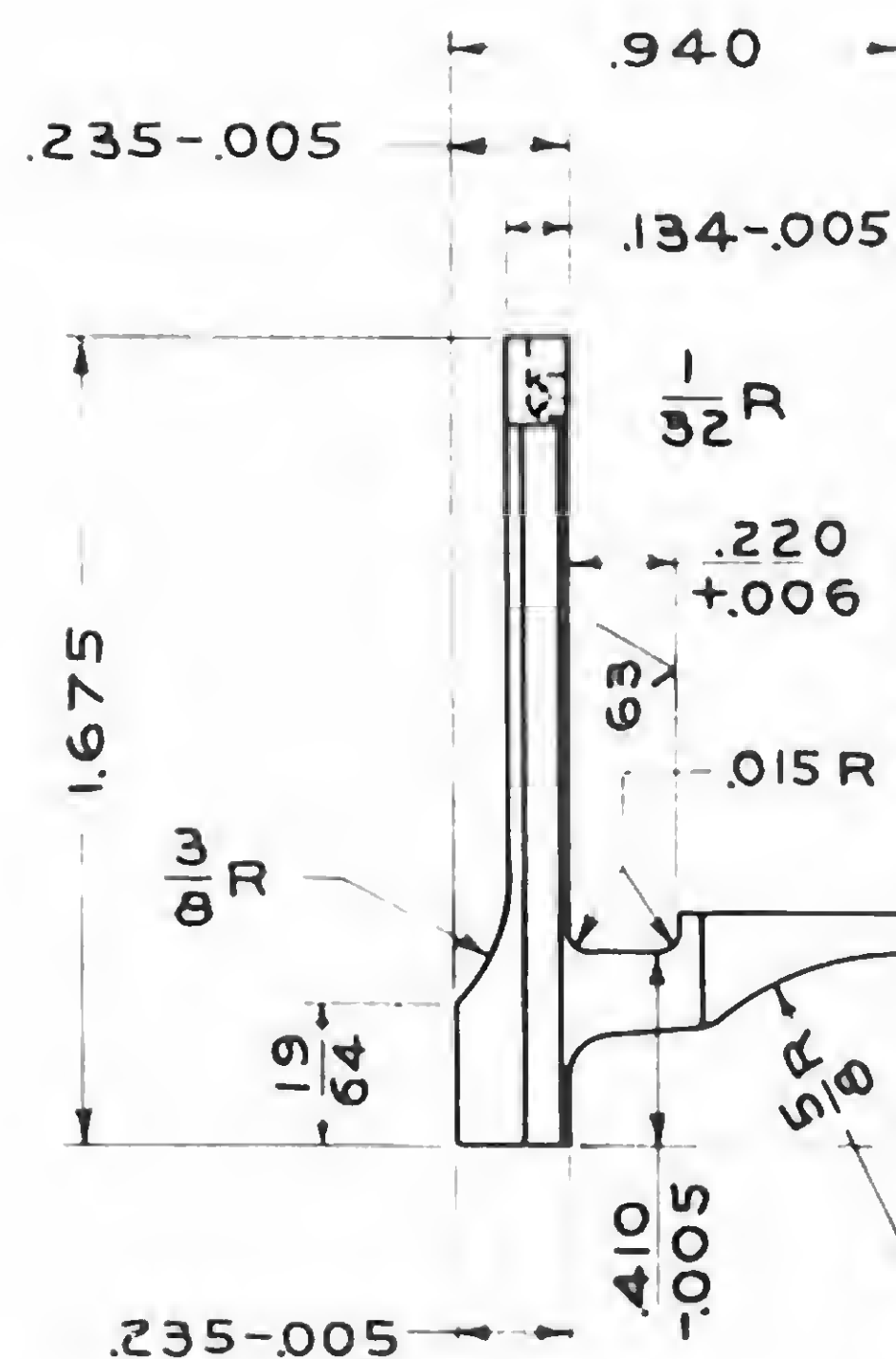
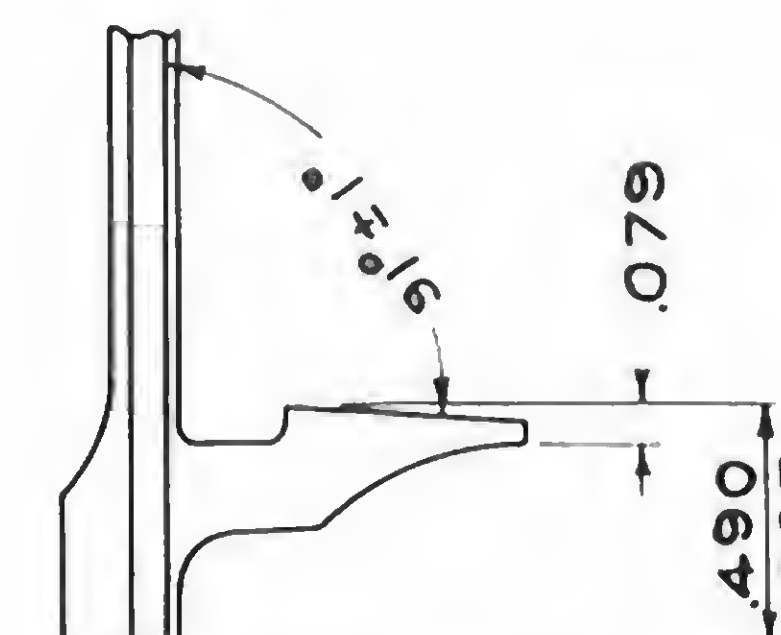
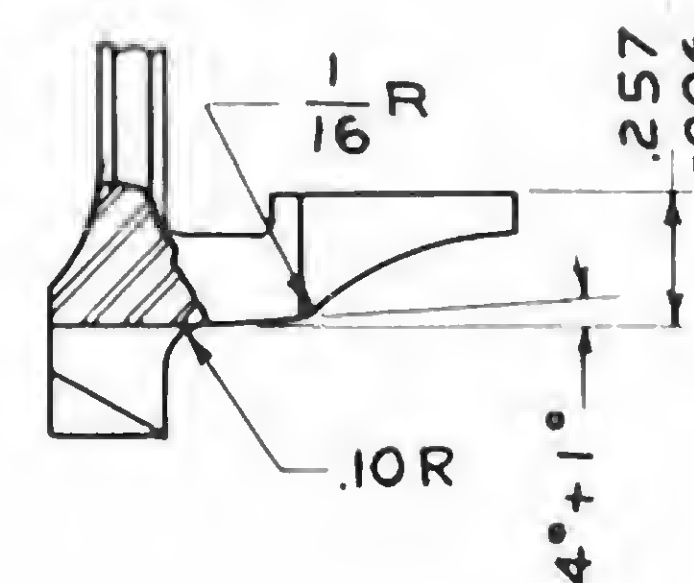
15 5-10-48

DRG. PERTAINS TO

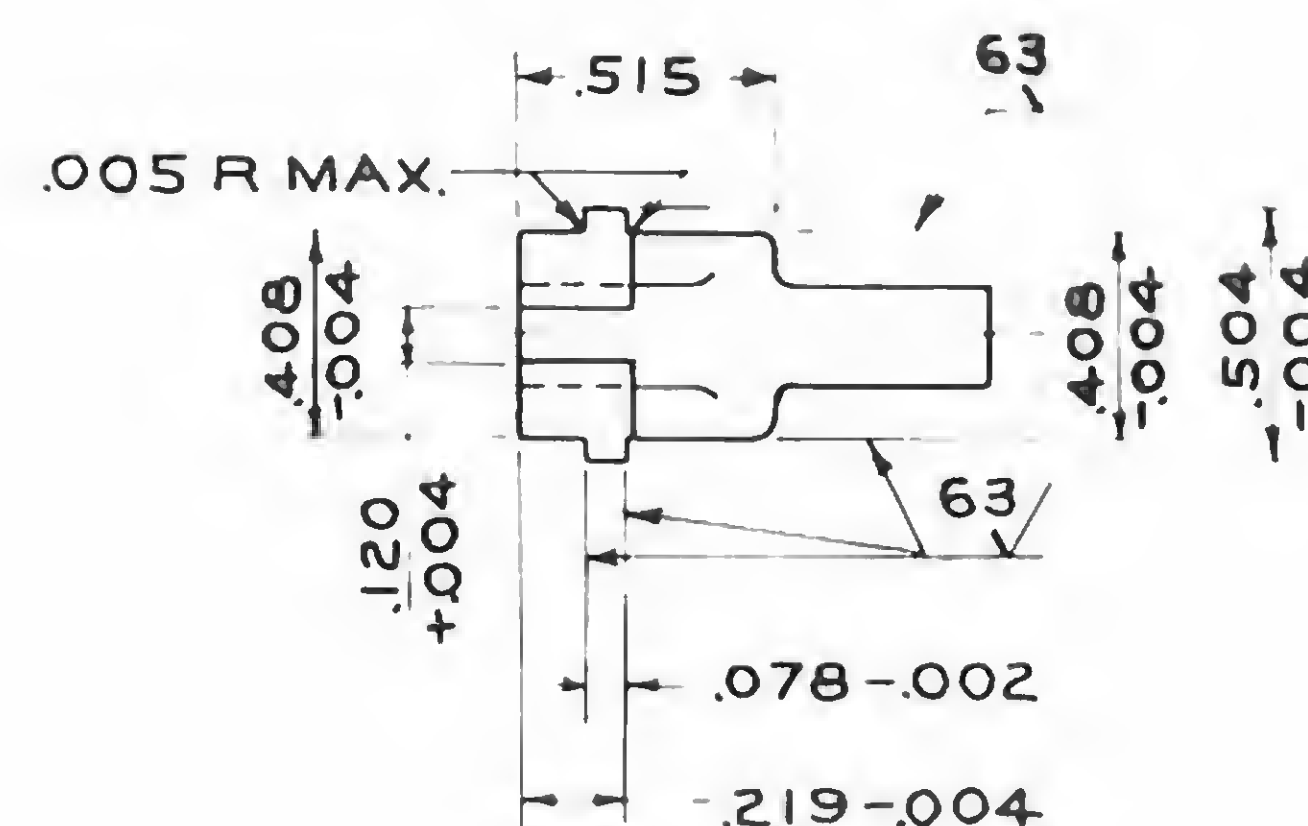
51-10-46	30 BMG M 17A1 (WC)
51-83-4	30 BMG M 19A4 (FXD)
51-84-4	30 BMG M 19A4 (FLEX)
51-114-4	30 BMG M 19A5 (FXD)
51-125-4	30 BMG M 19A6



NOTE:
PERMISSIBLE VARIATION OF
ANGLE MUST BE WITHIN
LIMITS DEFINED BY LOCATING
DIMENSIONS.

INSCRIBE PART NO. $\frac{1}{16}$ HIGH

ALTERNATIVE METHOD
OF MANUFACTURE



SEAR
STEEL FS 4140 5564137

FINISH 125/, OTHER SURFACES, AS SPECIFIED

SCALE $\frac{2}{1}$

WAS C64137

INSCRIBE PART NO.

C 5564137

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± .005
FRACTIONAL ± 1/64
ANGULAR ±

DRAFTSMAN	TRACER	L.D. DRAFTSMAN
C.S.S.	A.V.C.	
CHECKER		CHIEF DRAFTSMAN
L.S.C.		

SUBMITTED:

A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

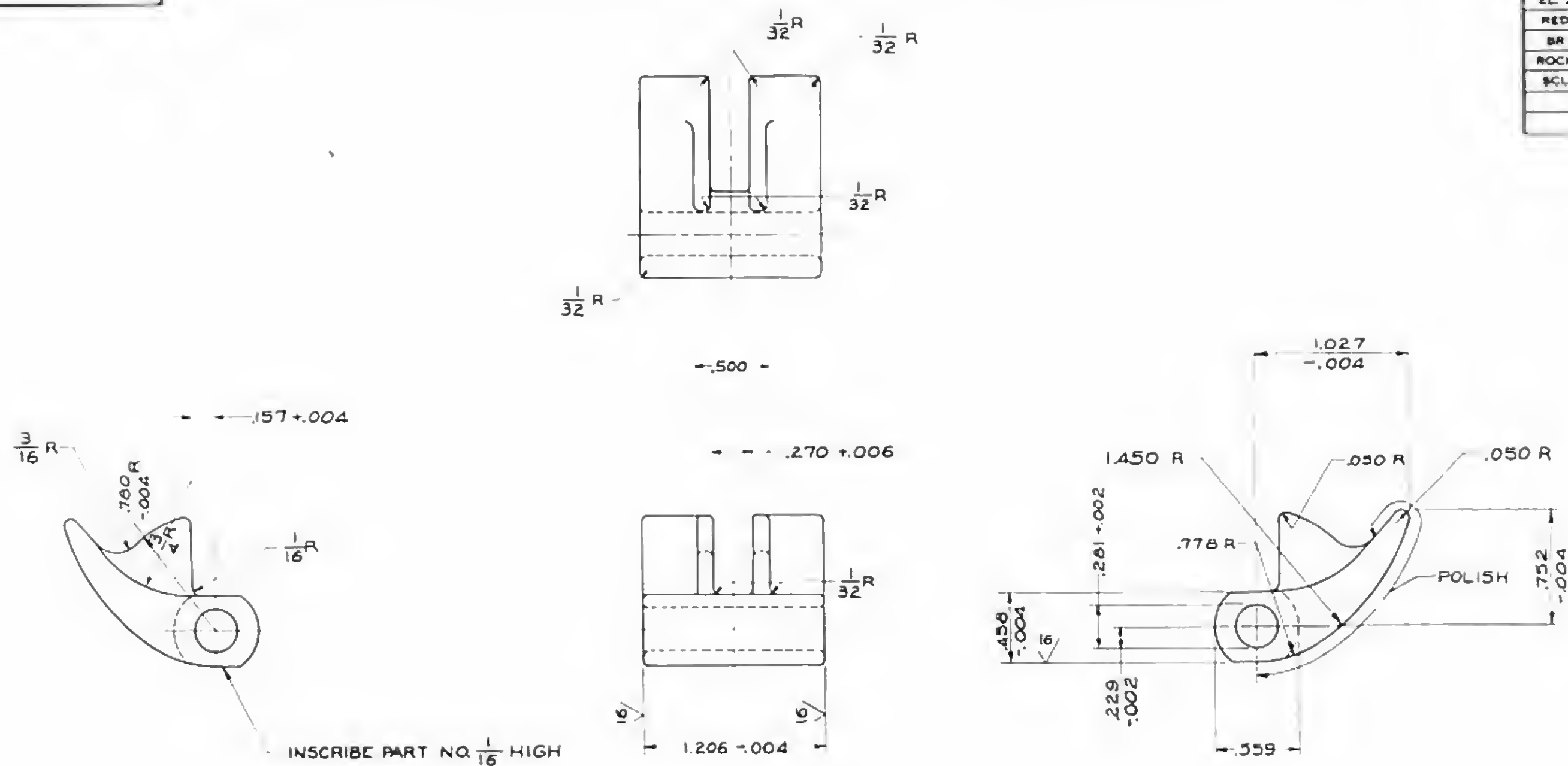
C5564137

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES		FEB. 1, 1938	
		REVISIONS	
Y. F.		14	5-10-48
T S			
EL 2			
RED			
BR			
ROCK	245-52		
SCL			
		DRG PERTAINS TO	

[illegible]

C5564142



ACCELERATOR (5564142)
STEEL FS 4340
FINISH ¹²⁵ ✓ OTHER SURFACES.
AS SPECIFIED

R.I.A. FORGING SHOWN ON DAG B7101532

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL = .005
FRACTIONAL = 1/64
ANGULAR = —

gmo-gram	reale	1-6-10-10-10-10
B. J. M. E. R. G.		
1-3-6-10-10		1-6-10-10-10-10

SUBMITTED
R.H. Roe
ORD DEPT U S A

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE
Walter Raskin
ORD DEPT U S A

ORDNANCE DEPT., U. S. A.

WAS CB4142

INSCREBE PART NO.

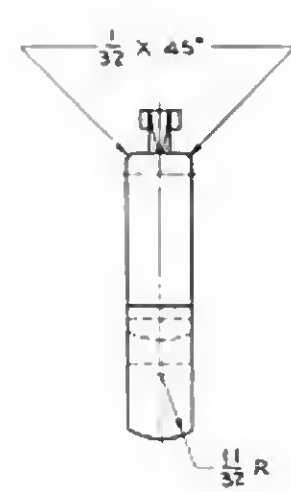
SCALE $\frac{2}{1}$

05564142

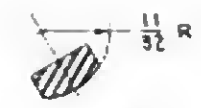
NOTES

[illegible]

⊕ PERMISSIBLE ANGLE TOLERANCE
MUST BE WITHIN LIMITS PRESCRIBED
BY LOCATING DIMENSIONS



SECTION A-A

[illegible]

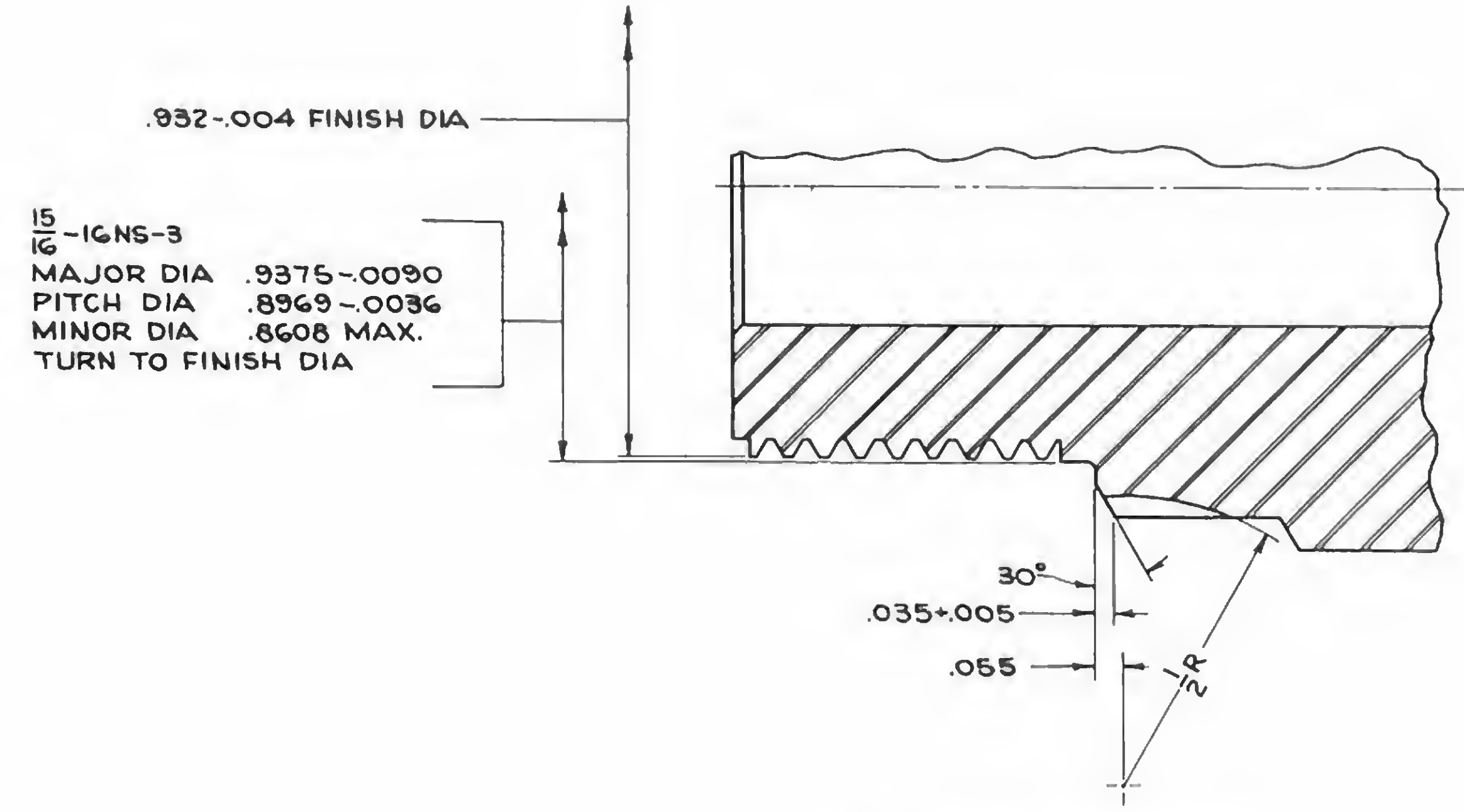
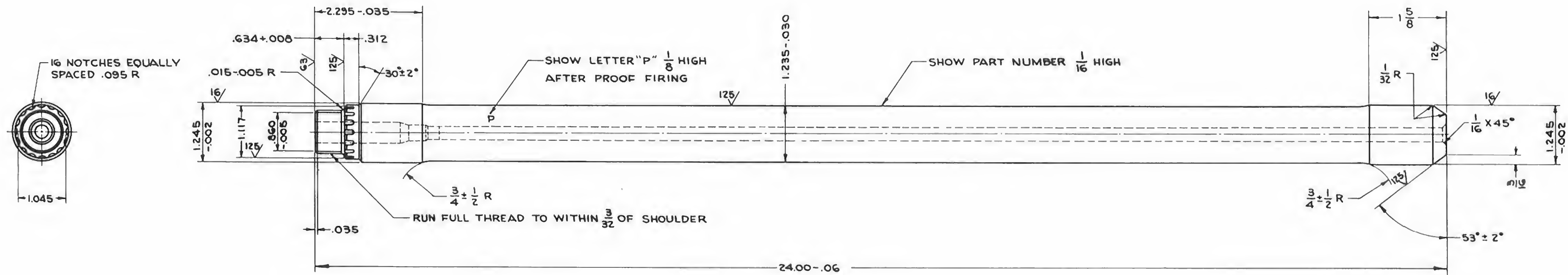
SEE NOTE APRIL 4, 1927 REVISIONS 22 5-10-48				CLASS DIVISION DRAWING FILE
TO EXAMINE OR DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL 2 008 FRACTIONAL 2 1/84 ANGULAR 2 0				TOLERANCE M. E. B.
DRG. PERTAINS TO 51-10-46 51-63-4 51-64-4 51-114-4 51-125-4				THE TOLERANCE THE MATERIAL SUBMITTED:
EXAMINED: APPROVED BY CHIEF OF THE CASE OF ORDNANCE Walter Anderson CHIEF OF THE CASE OF ORDNANCE				D5508476 ORDNANCE DEPT. U.S.A. MADE BY WESTINGHOUSE

SUPERSEDES C8476 & C7100010 WO/C 5-10-48

HEAT TREATMENT AND FINAL FINISH
TO MEET PHYSICALS AND HARDNESS
OF U.S.A. SPEC. 57-107-25 (10-14-46)
TYPE II FINISH, CLASS B (EXCEPT BORE)

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL.2	
RED	
BR	
ROCK	
SCL.	

D6535233



SECTION SHOWING
THREADS AND NOTCH CUT
SCALE $\frac{5}{1}$

BARREL
STEEL WD 4150 MOD
FINISH $\frac{32}{V}$, OTHER SURFACES, AS SPECIFIED

D6535233

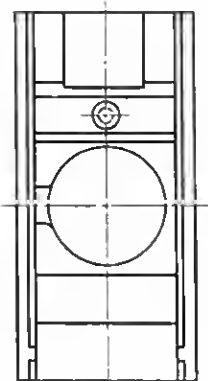
NOTE: FOR CHAMBER AND RIFLING
SEE DRAWING C64321

NOTE:
WHEN CHAMBER AND RIFLING ARE IN
ACCORDANCE WITH DRG C64321, DATED
3-7-42, THIS PART NUMBER SHOULD BE
USED.

SCALE $\frac{1}{1}$
WAS D35233

DO INSCRIBE PART NO.	
SEPTEMBER 30, 1936	
REVISIONS	
22	5-10-48
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$	
DESIGNED F.B.	TRIGGER L.S.C.
CHUCKER L.S.C.	ENTR/DEPT/INSTR
DRG. PERTAINS TO	
51-83-4	30 BORE
51-84-4	30 BORE
51-114-4	30 BORE
SUBMITTED: <i>A.M. Poe</i>	
EXAMINED:	
ORD. DEPT. U.S.A.	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:	
<i>Walter Ackerman</i>	
ORD. DEPT. U.S.A.	
ORDNANCE DEPT., U.S.A.	
MADE AT ROCK ISLAND ARSENAL	

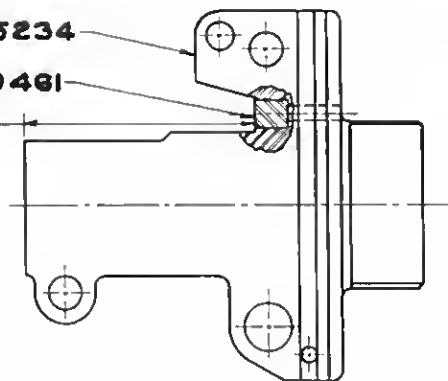
HEAT TREATMENT AND FINAL FINISH



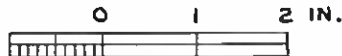
BLOCK-D 6535234

PLATE-A 5160481

GRIND FLUSH
TO $2.521 \pm .006$



BLOCK, TRUNNION, ASSEMBLY (6147093



PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

SEPT. 30, 1936

REVISIONS

7	5-10-48	

DRG. PERTAINS TO

06535358 EX-1 FLEX
540989 M1A5 FKH
0714037 M19A6

DO NOT
INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNED P.J.R.	TRACED O.K.	CHECKED S.S.	CHECKED S.S.	CHECKED S.S.

SUBMITTED:

J.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B147093

B 6147093

AG147093

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A 5160461

MARCH 10, 1939

HEAT TREAT

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

C 58-61

REVISIONS

6 5-10-48

DRG. PERTAINS TO

86147093

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS

NOT OTHERWISE SPECIFIED

DECIMAL \pm —FRACTIONAL \pm —ANGULAR $\pm 5^\circ$

DRAFTSMAN

M. J.

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKED

L. S. C.

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

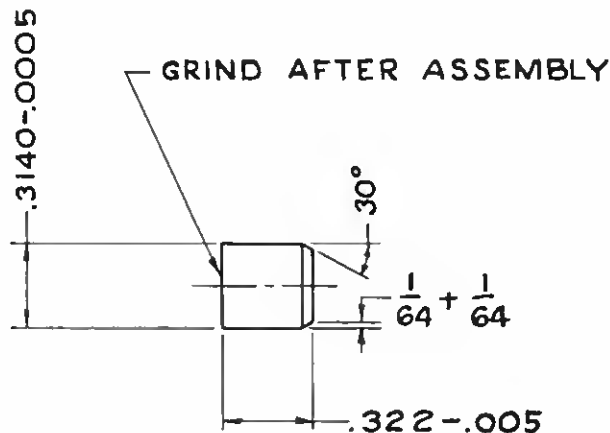
APPROVED BY ORDER OF THE CHIEF

OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



PLATE, BUNTER

STEEL FS 1095

FINISH 125/

5160461

SCALE $\frac{2}{1}$

WAS A 160461

A 5160461

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

SEPT. 30, 1936

REVISIONS

7 5-10-48

DRG. PERTAINS TO

06535358
540989
07114037

EX. 1 (FLEX)
MITAS (FXD)
M1946

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: -
FRACTIONAL: -
ANGULAR: -

DESIGNER
P.J.R.
CHECKED
L.S.
TRACER
O.K.
C.H.E. DRAFTER
G.P.

SUBMITTED:

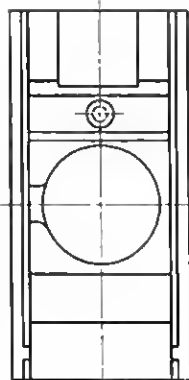
A.H. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

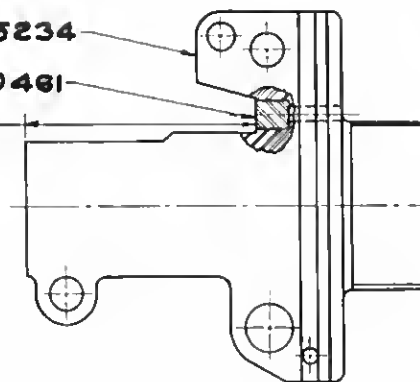
Walter Ackerman
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

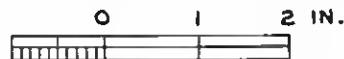


BLOCK-D 6535234

PLATE-A 5160481
GRIND FLUSH
TO 2.521 ± .006



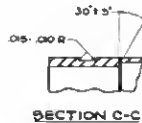
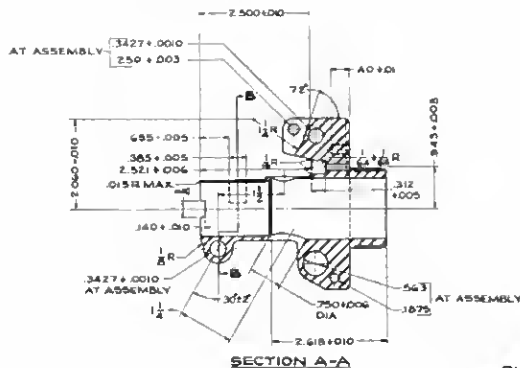
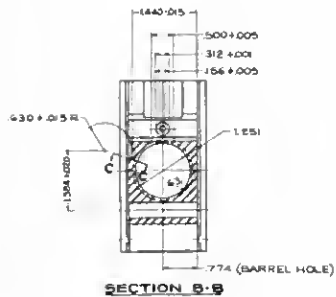
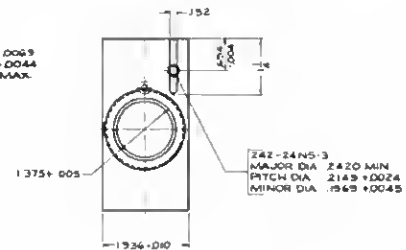
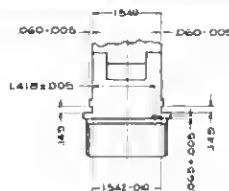
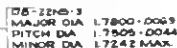
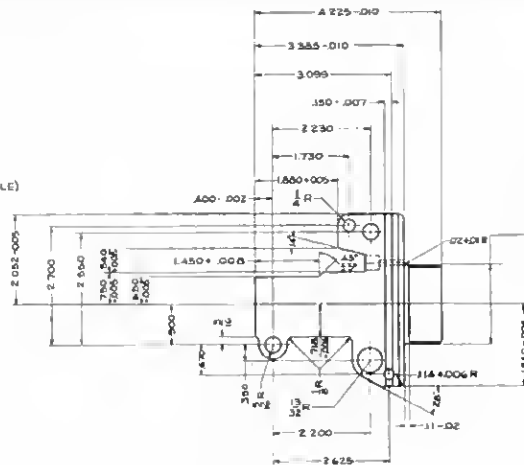
BLOCK, TRUNNION, ASSEMBLY (6147093



WAS 8147093

B 6147093

6147093



NOTE. WHEN USING MALLEABLE IRON SPECIAL-CLASS B, BUNTER PLATE A5160461 AND MACHINING FOR SAME MAY BE OMITTED AND FRONT SURFACE OF FEEDWAY FLAME HARDENED TO A MINIMUM HARDNESS OF ROCK C33

BLOCK TRUNNION (635234)
STEEL F81050
FINISH 125, OTHER SURFACES, AS SPECIFIED

WAS D35234

SCALE 4

[illegible]

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

FEB. 1, 1938

REVISIONS

Y. P.

T. S.

EL. 2

RED.

BR.

ROCK

SCL.

9 5-10-48

DRG. PERTAINS TO

51-114-1	.30 BMG M19A3(FXD)
51-83-1	.30 BMG M19A4(FXD)
51-84-1	.30 BMG M19A4(FLEX)
51-10-1	.30 BMG M17A1(WC)
51-125-1	.30 BMG M19A6

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL \pm —
ANGULAR \pm —

DRAFTSMAN
G.A.F.TRACER
O.K.

L.D.G. DRAFTSMAN

CHECKED
G.A.F.

6%

CHIEF DRAFTSMAN

SUBMITTED:

J.H. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter Ackerman

ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

BOLT-D6535408

PLATE-A135255

INSCRIBE PART NO. $\frac{1}{16}$ HIGH

GRIND FLUSH WITH FACE OF BOLT

BOLT, ASSEMBLY (6147299

WAS B147299

B6147299



B6147299

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JULY 15, 1931.

HEAT TREAT

Y.P.

RED.

ROCK.

C54-59

REVISIONS

T.S.

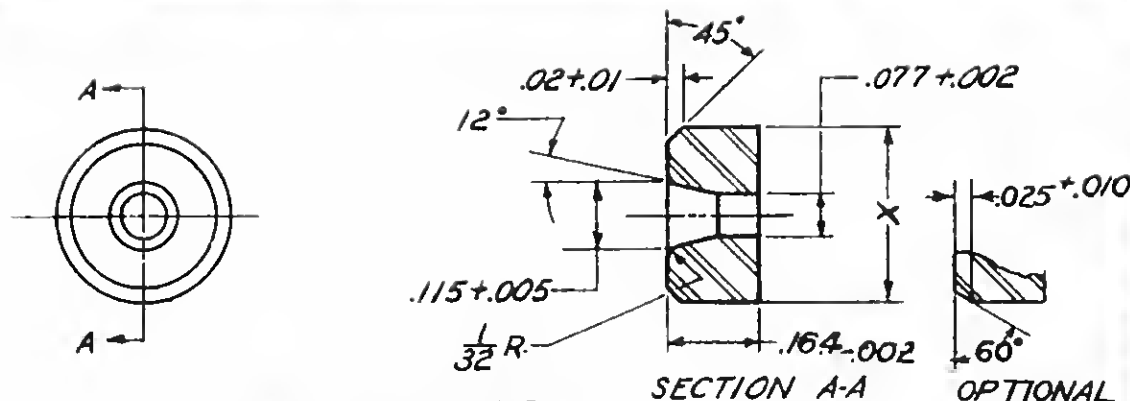
BR.

EL2

10 9-11-42

11 7-27-43

12 12-22-43

PLATE, RECOIL

X = .3125 - .0005

X = .3120 - .0005

X = .3130 - .0005

X = .3140 - .0005

X = .3150 - .0005

A 135255-12
 A 135255A-12
 A 135255B-12
 A 135255C-12
 A 135255D-12

STEEL-WD 1095

FINISH J

MANUFACTURING COMPONENT

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING A-135255

UNDER REVISION DATE OF SEPT. 11, 1942.

SCALE $\frac{4}{1}$

SPRINGFIELD ARMORY

A135255

DR'G. PERTAINS TO

ALL 30 BMG-M12
 51-10 30 BMG-M17A1 (WC)
 51-83 30 BMG-M19A4 (FXD)
 51-84 30 BMG-M19A4 (FLEX)
 51-114 30 BMG-M19A5 (FXD)
 C3961 BOLT, ALTERNATE
 FEED ASSEMBLY
 B147299 BOLT, ASSEMBLY
 51-125 30 BMG-M19A6

DFTSMAN

TRACES

LOG. DFTSMAN

F.D.U.

L.D.U.

L.D.U.

CHECKER

L.D.U.

L.D.U.

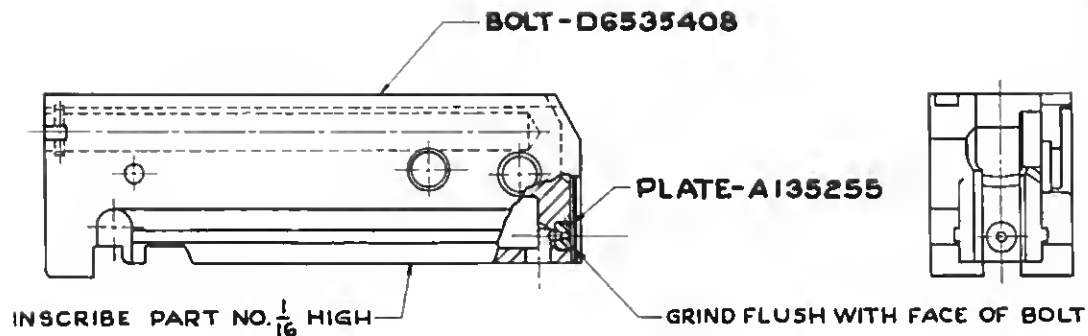
SUBMITTED.

APPROVED BY ORDER OF THE
 CHIEF OF ORDNANCE:

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

**BOLT, ASSEMBLY** (6147299

WAS B147299

B6147299PHYSICAL
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED.	
BR.	
ROCK	
SCL.	

FEB. 1, 1938

REVISIONS

5-10-48		

DRG. PERTAINS TO

51-114-1	.30 BMG M19A3(FXD)
51-83-1	.30 BMG M19A4(FXD)
51-84-1	.30 BMG M19A4(FLEX)
51-10-1	.30 BMG M17A1(WC)
51-125-1	.30 BMG M19A6

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL \pm —
ANGULAR \pm —

DRAFTSMAN G.A.F.	TRACER O.K.	L.D.G. DRAFTSMAN
CHECKER J.S.		CHIEF DRAFTSMAN

SUBMITTED:

F.H. Roe
ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ashmun
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

B6147299

HEAT TREATMENT AND FINISH
TYPE B FINISH, CLASS B

PHYSICAL
PROPERTIES
Y.P.T.
T.S.
EL. 2
RED.
BR.
DCA
SCA

*PLATE, ASSEMBLY-C55G4222

RIVET-A5020522

PLATE-DG535393

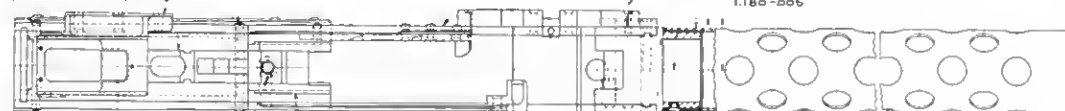
RIVET-A5020711

RIVET-A5160656
(GRIND FLUSH INSIDE & OUTSIDE)

NOTE A
4 OF HOLE MUST BE SQUARE WITH
THIS 4 WITHIN .003 IN SIX INCHES

SCREW UP TIGHT AGAINST SHOULDER AND
SWEAT THREADS WITH HIGH TEMPERATURE
SOLDER (500°F MINIMUM MELTING POINT)

2.355
1.180-.005



DRAW SCREW UP TIGHT,
BACK OFF $\frac{1}{8}$ TO $\frac{1}{4}$ TURN AND
STAKE IN TWO PLACES ON
INSIDE OF CASING

*PLATE, ASSEMBLY-C55G4224

CAM-C5664133

SCREW-A5020527

190-.32NF±.2, COUNTERSINK .62" TO $\frac{3}{8}$ " DIA

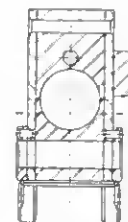
*BLOCK, ASSEMBLY-BG147053

RIVET-A5020601 (GRIND FLUSH OUTSIDE)

RIVET-A5020600 (GRIND FLUSH OUTSIDE)

SCREW-BCLX1.1, 100866 (STAKE)

JACKET-C5562503

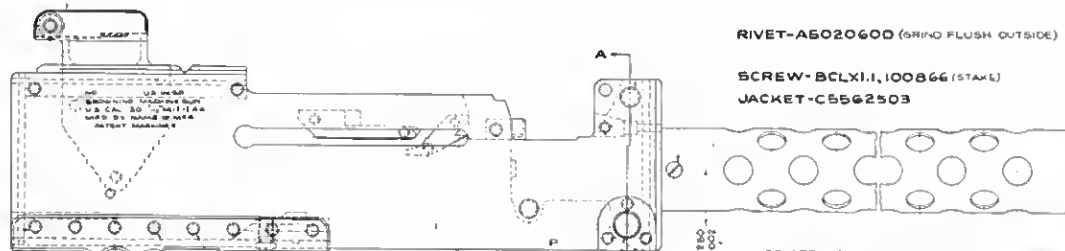


FACES OF REAR
MOUNTING LUGS
MUST BE CENTRAL
WITH FACES AT FRONT
MOUNTING HOLES
WITHIN .010

NOTE B
4 OF MOUNTING HOLE MUST
BE SQUARE WITH THIS 4
WITHIN .003 IN SIX INCHES

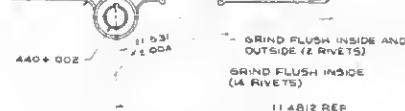
BASE-C5545965

SECTION A-A



RIVET-A5152737

PLATE-06535392



SHOW LETTER
P $\frac{1}{8}$ " HIGH AFTER
PROOF FIRING

SQUARENESS OF 4 OF FRONT
MOUNTING HOLE AS MEASURED
AT FACES OF ADAPTER PLATES
SHALL BE WITHIN THESE PRE-
SCRIBED LIMITS AND SHALL
CONFORM TO LIMITS SPECIFIED
IN NOTE A AND NOTE B

*FINDING DIAGRAM

REV. NO. PART NO.
REV. NO.

SEPTEMBER 30, 1936	NAME	DESIGN	REVISION	FILE
17-3-15-48				
TOLERABLE ON LONG REARS NOT OTHERWISE SPECIFIED DIMENSIONS .005 FRACTIONS .005 ANGLES 1/2"				
W.C.D. Z.C.				
DRO. PERMISSIBLE TO				
ST-8.3-1				
ST-8.4-1				
EXAMINED				
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE				
M. J. L. L. L.				
ORDNANCE DEPT. U.S.A.				

CASING, ASSEMBLY C555355B

WAS D35358

0 1 2 3 4 5 6 7 8 9 10 11 IN

100% BY X-RAY INSPECTION

A5020522

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

APRIL 4, 1927

REVISIONS

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

12 5-10-48

DRG. PERTAINS TO

D6535358

.30 BMG 19A4
(FXD) & (FLEX)

D6540989

.30 BMG
M19A8 (FXD)

D7114037

.30 BMG
M19A6

D6901301

.30 BMG
M17A1 (WC)INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL \pm .005FRACTIONAL \pm —ANGULAR \pm 5°

DRAFTSMAN

J.J.V.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.S.C.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

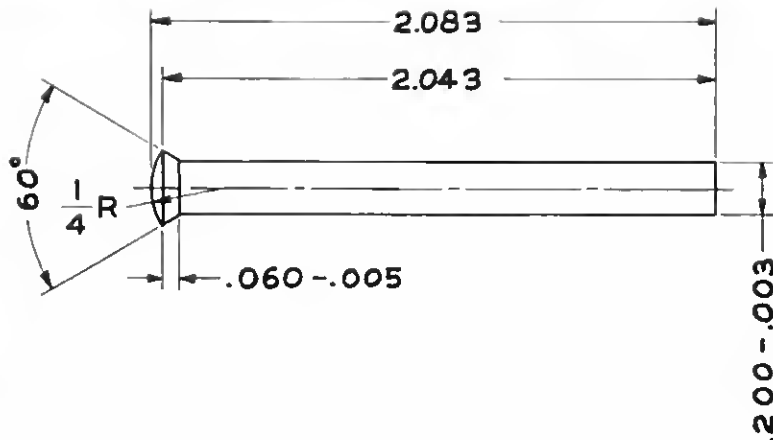
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



RIVET, TOP PLATE, LONG

STEEL FS 1035

FINISH 125/

5020522

WAS A20522

SCALE $\frac{2}{1}$

A

5020522

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A 5020527

APRIL 4, 1927

Y. P.

RED.

SCL

T. S.

BR.

EL. 2

ROCK

REVISIONS

15 5-10-48

DRG. PERTAINS TO

D7114037

.30 BMG
MIFAG

D6901301

.30 BMG
MITAI(WC)

D6540989

.30 BMG
MITAI(FX)

D6535358

.30 BMG 1914
(FXD)(FLEX)

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

R.G.D.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKER

W.B. [Signature]

O.D.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

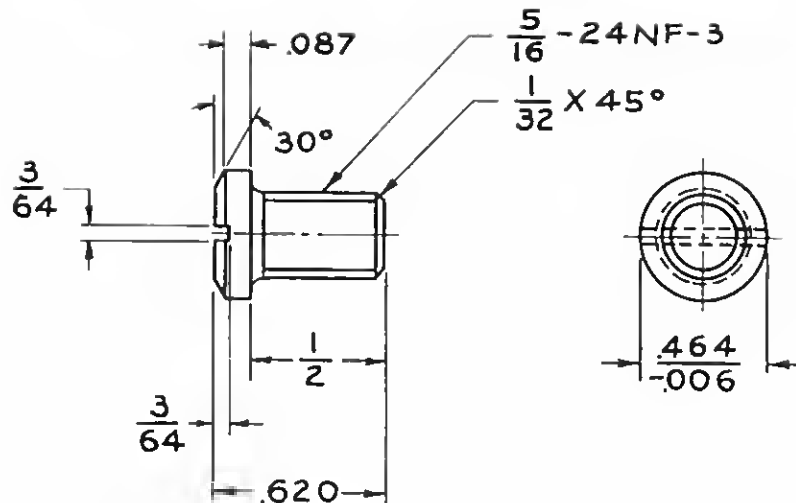
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter [Signature]

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SCREW, BREECH LOCK CAMSTEEL FSX1315

FINISH 125/

5020527

SCALE $\frac{2}{1}$

WAS A20527

A 5020527

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A 5020600

JUNE 1, 1931

REVISIONS

11 5-10-48

DRG. PERTAINS TO

D6535358

30 BMG 19A4
(FXD) & (FLEX)

D6540989

30 BMG
M19A5 (FXD)

D7114 037

30 BMG
M19A6

D6901301

30 BMG
M19A1 (WC)~~DO~~INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL \pm —FRACTIONAL \pm 1/64ANGULAR \pm 5°

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

C.O.G. DRAFTSMAN

CHECKER

L.S.C.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. ROE

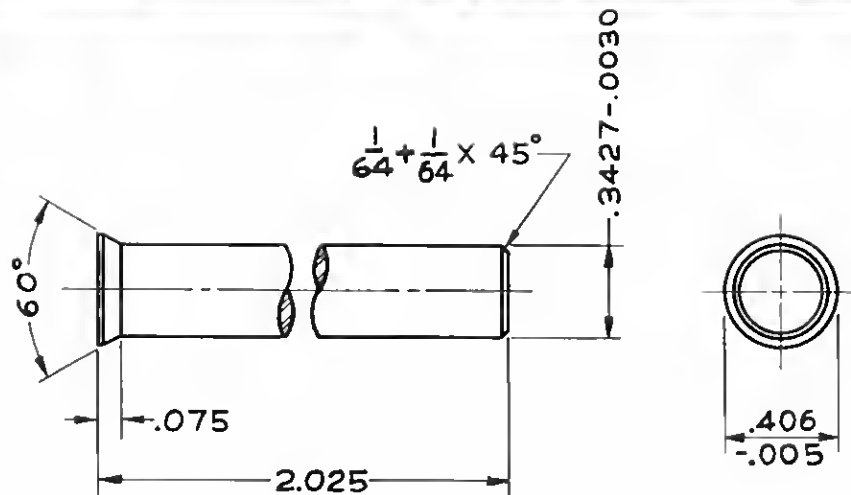
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

RIVET, SIDE PLATE, LARGESTEEL FS1035

FINISH 125/

5020600

WAS A20600

SCALE $\frac{2}{1}$ | A | 5020600

MADE AT ROCK ISLAND ARSENAL

A 5020601

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 1, 1931

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

125-10-48

DRG. PERTAINS TO

D6535 358

30 BMG 19A4
(FXD) (FLEX)

D6540 989

30 BMG
M19A5 (FXD)

D7114 037

30 BMG
M19A6

D6901 301

30 BMG
M17A1 (WC)

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

CHIEF DRAFTSMAN

SUBMITTED:

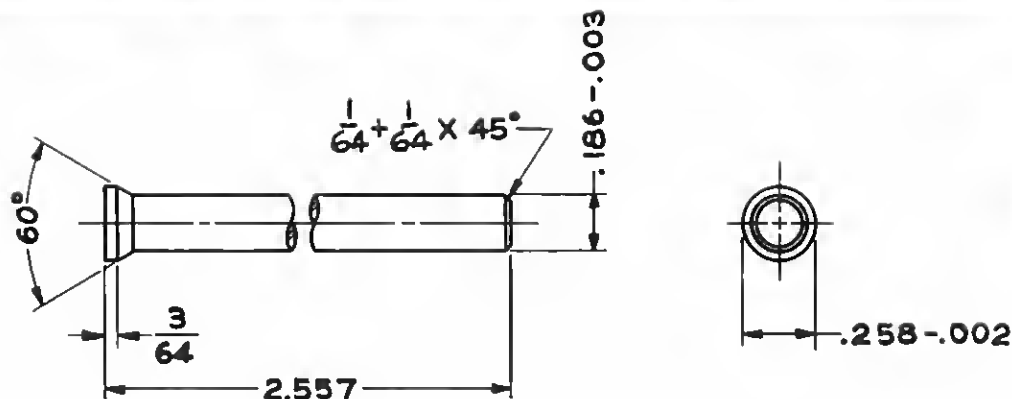
A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Ackerman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

RIVET, SIDE PLATE, SMALLSTEEL FS1035FINISH 125

5020601

WAS A20601

SCALE $\frac{2}{1}$

A

5020601

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A 5020711

APRIL 4, 1927

REVISIONS

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

195-10-48

DRG. PERTAINS TO

D6535358

30 BMG 19A4
(PXD) 8 (FLEX.)

D7114037

30 BMG
M19A6

D6901301

30 BMG
M17A1 (WC)INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5'$

DRAFTSMAN

E.L.L.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKER

E.W.H.

CHIEF DRAFTSMAN

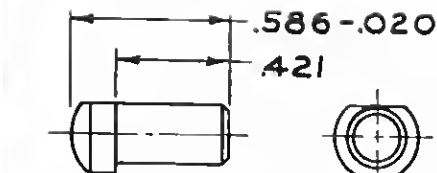
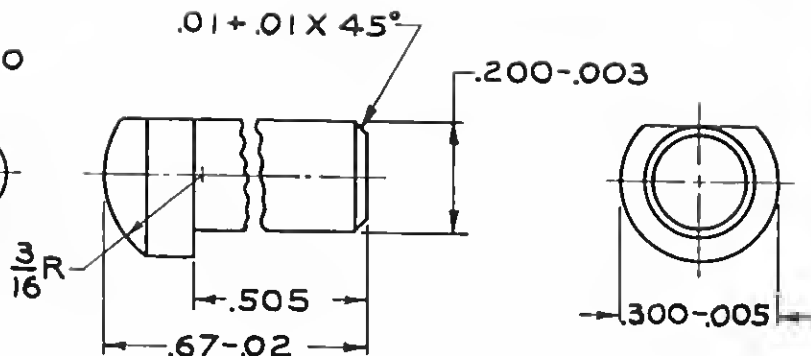
O.O.

SUBMITTED:

*A.H. Roe*APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Ackerman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

ALTERNATIVE
METHOD OF MFG.SCALE $\frac{2}{1}$ RIVET, TOP PLATE, SHORT
STEEL FS1035FINISH 125/
 $\sqrt{}$

(5020711

WAS A20711

SCALE $\frac{4}{1}$

A 5020711

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A5152737

FEB. 1, 1938

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

8 5-10-48

DRG. PERTAINS TO

06535358

.30 BMG 1944
(FXD) & (FLEX)

06540989

.30 BMG
M19A5 (FXD)

07114037

.30 BMG
M19A6

06901301

.30 BMG
M17A1 (WC)INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm -$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

J. A. B.

E. R. G.

CHECKER

O. O.

CHIEF DRAFTSMAN

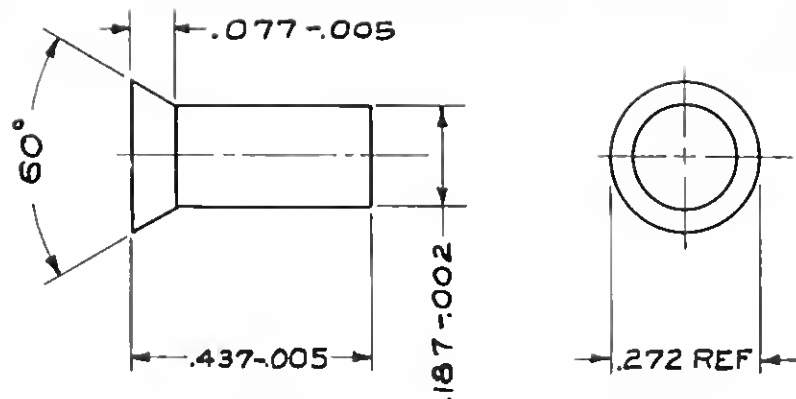
SUBMITTED:

A. H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:Walter A. K...
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

RIVET, BOTTOM PLATESTEEL FS1035

FINISH 125

5152737

WAS A152737

SCALE $\frac{4}{1}$

A

5152737

A 5160656

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

REVISIONS

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

4 5-10-48

DRG. PERTAINS TO

D6535358

30 BMG M1944
(F&D & FLEX)

D7114037

30 BMG
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL \pm —
ANGULAR $\pm 2^\circ$

DRAFTSMAN
M.T.TRACER
O.K.

L'D'G DRAFTSMAN

CHECKER
LSC

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

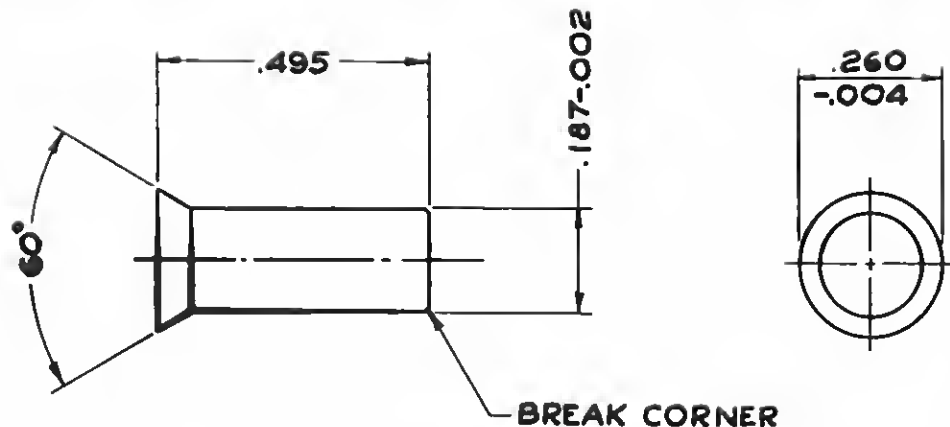
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

RIVET SIGHT BRACKET (5160656)STEEL FS1035

FINISH 125/

WAS A160656

SCALE $\frac{4}{1}$

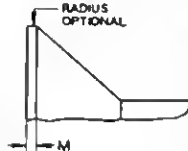
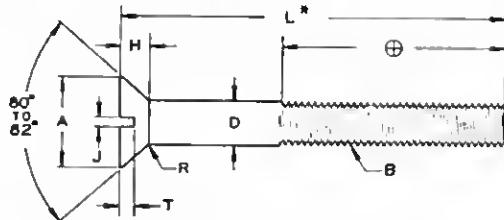
A 5160656

SCREW, MACHINE, FLAT HD. (NF-2) STEEL

BCLXI.1

ORDNANCE DEPT. STANDARDS (COMMERCIAL)

APPROVED 7-25-31
DATE



NOMINAL SIZE	#10	#12	1/4	5/16	3/8		
B THREADS PER INCH	32	28	28	24	24		
D DIAMETER OF BODY	Max. .1900 Min. .1670	.2160 .1997	.2500 .2237	.3125 .2821	.3750 .3426		
A DIAMETER OF HEAD	Max. .385 Sharp Min. .359 Abs. Min. .343	.438 .410 .397	.507 .477 .462	.635 .600 .581	.762 .722 .700		
M WIDTH OF FLAT	Max. .007 Min. .116	.008 .132	.009 .153	.011 .191	.013 .230		
H HEIGHT OF HEAD	Max. .098 Min. .060	.112 .067	.131 .075	.165 .084	.200 .094		
J WIDTH OF SLOT	Max. .050 Min. .051	.056 .060	.064 .070	.072 .088	.081 .106		
T DEPTH OF SLOT	Max. .034 Min. .062	.039 .071	.046 .071	.053 .083	.070 .083		
R RADIUS							

L LENGTH

ORDNANCE PART NUMBER - STANDARDS - PLAIN FINISH

3/16	420601	420602					
1/4	100666	420603	420620				
5/16	112878	420604	420621				
3/8	100667	420605	420622	420631			
7/16	117633	420606	420623	420632			
1/2	100668	420607	191579	420633	420644		
5/8	100669	420608	178743	420634	119481		
3/4	100670	420609	420624	420635	177545		
7/8	100671	420610	190738	137504	420645		
1	100672	420611	188739	151746	111636		
1-1/8	100673	420612	420625	150799	420646		
1-1/4	100674	420613	188741	420636	125910		
1-1/2	100675	420614	1631	420637	1904		
1-3/4	100676	420615	420626	420638	19045		
1-7/8	100677	420616	420627	420639	420651		
2	100678	420617	420628	420640	192344		
2-1/4	117634	420618	420629	420641	420647		
2-1/2	117635	420619	420630	420642	420648		
2-3/4	117636			420643	420649		
3	117637				420650		

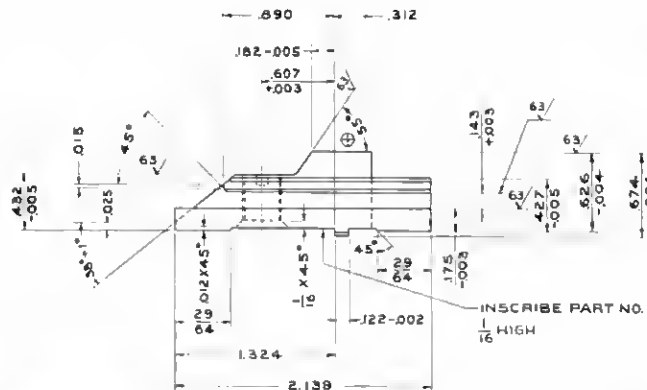
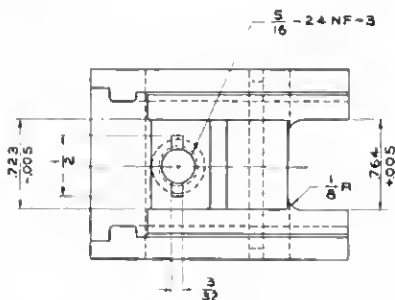
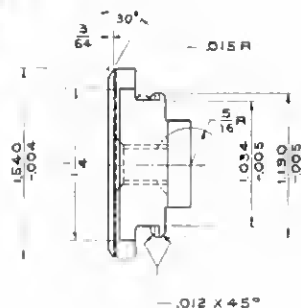
MATERIAL: STEEL, COMMERCIAL, WD-1010 - 1020.

NOMENCLATURE PATTERN: SCREW, MACHINE, FLAT HD, S., PLAIN FINISH, #10 - 32NF-2 x 1", DRG. BCLXI.1, PART NO. 100672.

⊕ LENGTH OF THREAD: ON SCREWS 2" LONG OR SHORTER, THREADS SHALL EXTEND TO WITHIN TWO THREADS OF THE BEARING SURFACE OF THE HEAD. LONGER LENGTHS SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH OF 1-3/4"

* TOLERANCE ON LENGTH: UP TO 1" MINUS 1/32; OVER 1" TO 2" MINUS 1/16; OVER 2" MINUS 3/32.

HEAT TREAT



CAM, LOCK, BREECH
STEEL FS 4140

5564133

FINISH $12\frac{5}{8}$, OTHER SURFACES, AS SPECIFIED

⊕ PERMISSIBLE ANGLE TOLERANCES NOT SPECIFIED MUST BE WITHIN LIMITS PERSCRIBED BY LOCATING DIMENSIONS

PHYSICAL PROPERTIES		FEBRUARY 1, 1938 REVIEWS	
V.P.		17	E-10-48
T.S.			
EL.			
RED.			
BR.			
ROCK	C48-54		
SCL.	--		
		DSC PERTAINS TO	

DRG. PERTAINS TO

06535358	30 BMG M19A4 (FAC) & (FLEA)
06540889	30 BMG M19A8 (F&D)
07114087	30 BMG M19A6
06901301	30 BMG M19A1 (WC)

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL = .005
FRACTIONAL = 1/64
ANGULAR = 5°

CLASS	AVC	DATE
-------	-----	------

SUBMITTED
14.8

DRG DEPT U S A

APPROVED BY CHIEF OF THE BUREAU
OF ORIGIN.

ORDNANCE DEPT. U. S. A.

地址: 中国北京 100084 中国科学院 1 区 1 号楼 101 室
电话: 010-64036448 传真: 010-64036448 电子邮箱: jingliang@im.ac.cn

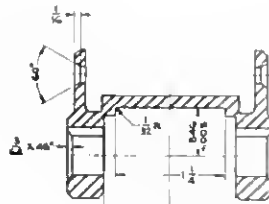
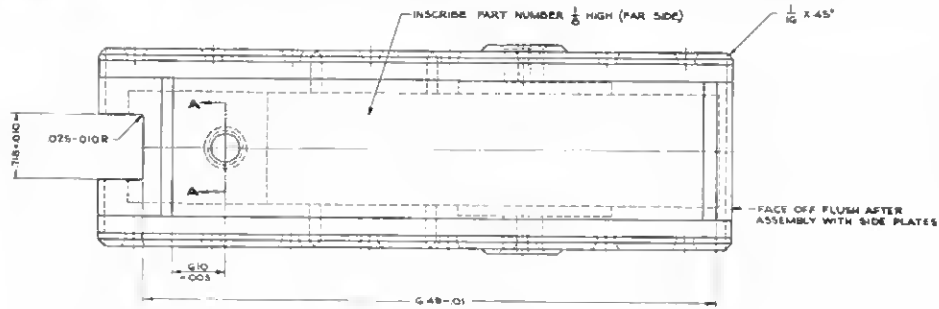
WAS C64133

INSCHINE PART NO.

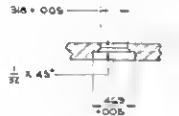
SCALE $\frac{2}{1}$

5564133

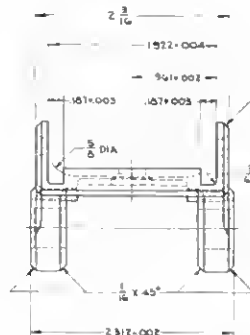
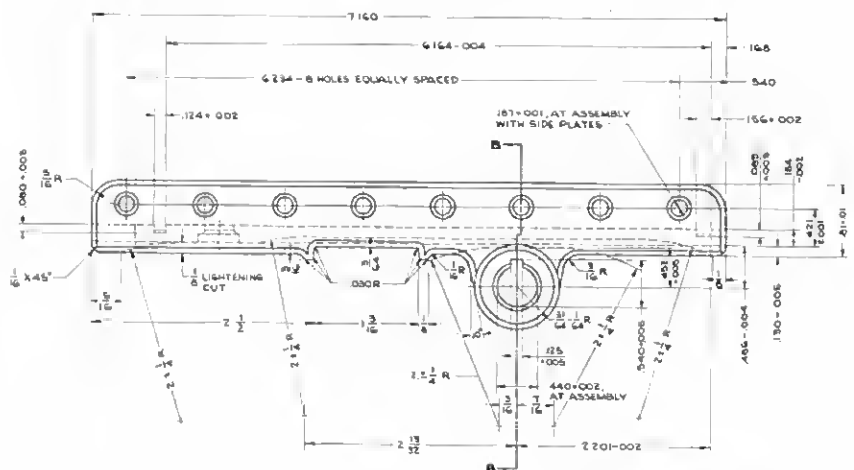
地址: 中国北京 100084 中国科学院 130 单元 1302 信箱
电话: 010-64033938 电邮: zhangyong@infocn.ac.cn



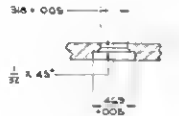
SECTION B-B



SECTION A-A



SECTION B-B



SECTION A-A

PLATE BOTTOM

STEEL # 61035

FINISH 11/ OTHER SURFACES, AS SPECIFIED

533392

R/A FORGING SHOWN ON DRG CP8464

SCALE 2:1
WAS D55932

FEBRUARY 1 1938		CLASS	REVISED	REVISION	FILE
REVISIONS					
17 5-10-48					
TOLERANCES ON DIMENSIONS NOT OTHERWISE SPECIFIED FRACTIONS 1/16 DECIMALS 0.015 ANGLES 1/2					
DRG PERTAINS TO					
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25545					

CARBON CASE FRONT HALF ONLY
004 TO 008 DEEP (ROCK A75-80)

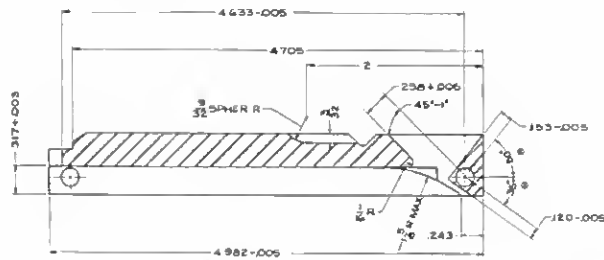
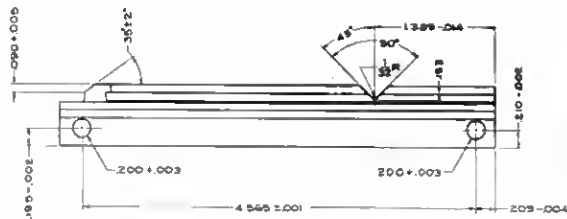
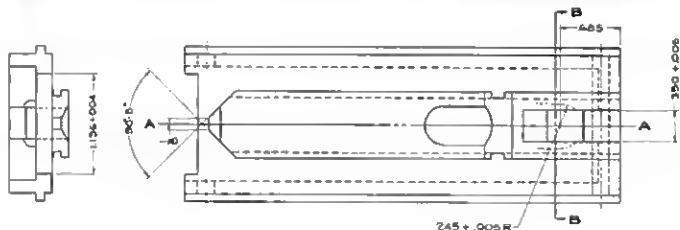
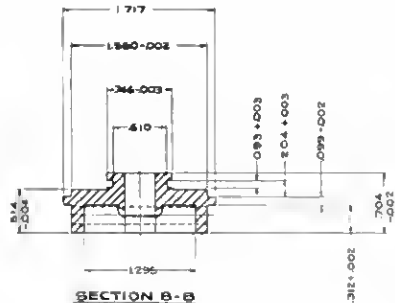


PLATE TOP
STEEL # 51045
FINISH 125



PERMISSIBLE ANGLE TOLERANCES NOT SPECIFIED
MUST BE WITHIN LIMITS PRESCRIBED BY LOCATING
DIMENSIONS.

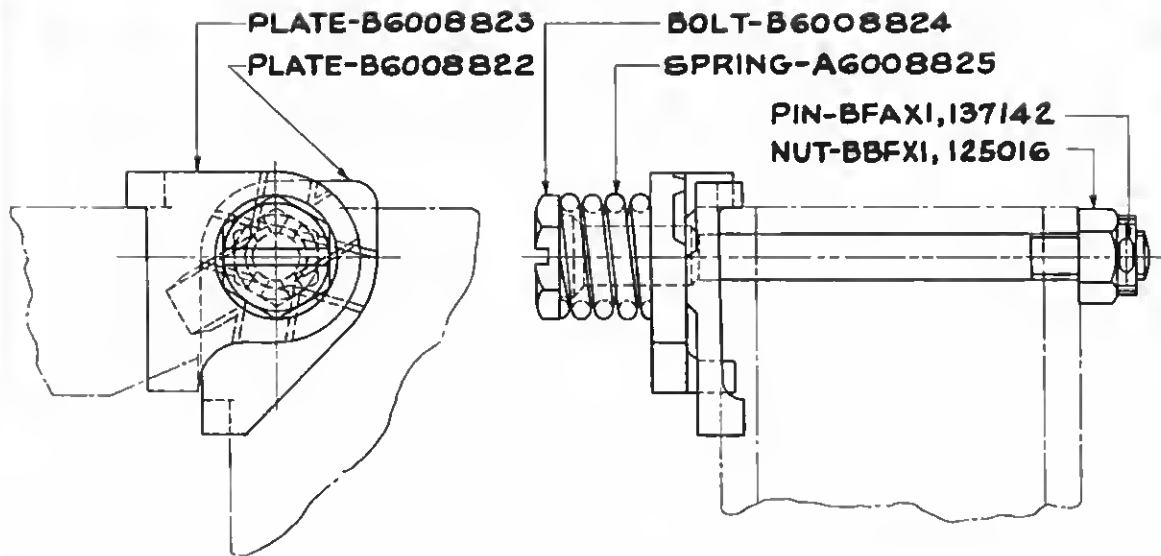
WAL 03539.1

SCALE 2.

[illegible]

06535393

HEAT TREATMENT AND FINAL FINISH



CATCH, COVER (6008757



PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

SEPT. 23, 1932

REVISIONS

9	5-10-48		

DRG. PERTAINS TO

51-125-1	30 BMG M19A6
51-84-1	30 BMG M19A4 (FLY)
51-10-1	30 BMG M17A1 (WC)
51-83-1	30 BMG M19A4 (FXD)

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL:—
FRACTIONAL:—
ANGULAR:—

PLATE	PLATE	PLATE
T.J.C.	M.C.	
CHIEF	CHIEF	CHIEF

SUBMITTED:

A.H. Roe

ORD. DEPT. - U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...
ORD. DEPT. - U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B8757

B 6008757

B6008757

A 6008825

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

SEPT. 23, 1932

HEAT AT 450° F IN OIL FOR 30 MINUTES
TYPE II FINISH, CLASS B

Y. P.		RED.		SCL.	
T. S.		BR.			
EL. 2		ROCK			

REVISIONS

13 5-10-48

DRG. PERTAINS TO

B6008757

30BMG-MITAIWC
M19A4(FXD)
M19A4(FLEX)
M19AG

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± -

FRACTIONAL ± -

ANGULAR ± -

DRAFTSMAN W.L.M.	TRACER M.C.	L'DG DRAFTSMAN
CHECKED <i>W.D.H.</i>	<i>W.D.H.</i>	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

DIAMETER OF WIRE _____ .100-.002
TOTAL NUMBER OF COILS _____ 4 1/2
MINIMUM INSIDE DIAMETER, FREE _____ .45
OUTSIDE DIAMETER, FREE _____ .660±.010
MAX. OUTSIDE DIA AT MIN OPERATING HEIGHT _____ .672
FREE LENGTH _____ 2 1/32 ± 1/32
TYPE OF ENDS _____ SQ & GD
WOUND _____ R.H.
MEAN ASSEMBLED HEIGHT _____ .450
MIN LOAD AT MEAN ASSEMBLED HEIGHT _____ 62. ± 6. LB
MIN OPERATING HEIGHT _____ 7/16
LB PER INCH OF SPRING DEFLECTION _____ 283.1
SPRING FUNCTIONS OVER ROD _____ .440
CALCULATED MAX. SOLID HEIGHT _____ .415

CAUTION: DO NOT COMPRESS SOLID.

SPRING, COVER CATCH

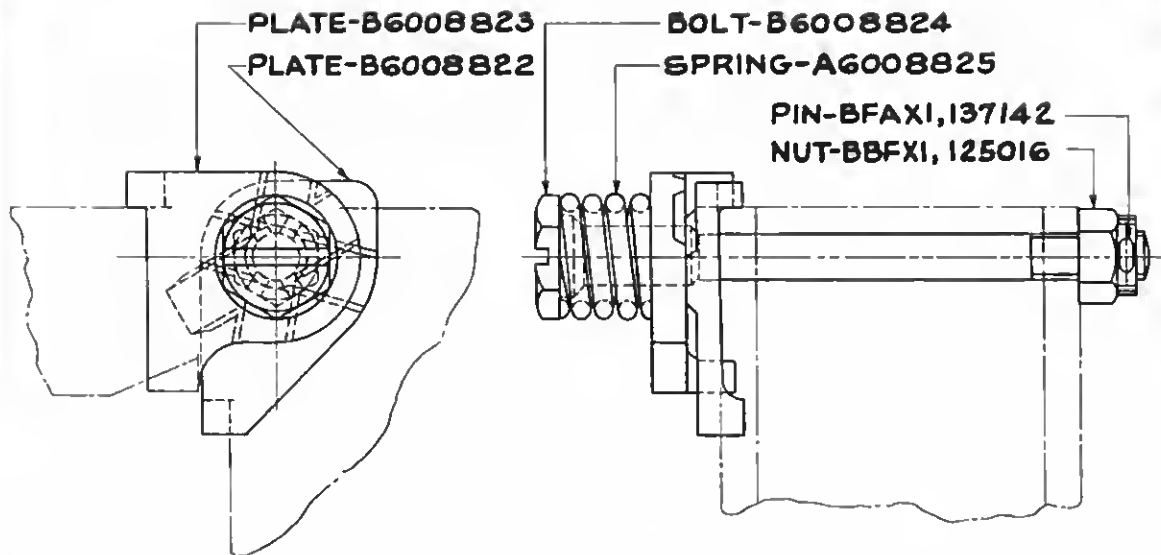
SPRING STEEL WIRE WD1085 SPECIAL-CLASS A

6008825

WAS 88825

A 6008825

HEAT TREATMENT AND FINAL FINISH



CATCH, COVER (6008757



PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

SEPT. 23, 1932

REVISIONS

9 5-10-48

DRG. PERTAINS TO

51-125-1 M1-A6
51-84-1 M1-A4 (FLX)
51-10-1 M1-A1 (WC)
51-83-1 M1-A4 (FXD)

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL:—
FRACTIONAL:—
ANGULAR:—

DESIGNED BY T.J.C. M.C. L.S. SAUTER
CHECKED BY G.A. L.S. SAUTER

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter A. ...
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B8757

B 6008757

B6008757

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

SEPT. 23, 1932

REVISIONS

14 5-10-48

PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK. A78-B3
SCL.
C.C. .015 TO .020

DRG. PERTAINS TO

5008757 30 BMG
M17A1(WC)
M19A4(FXD)
M19A4(FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

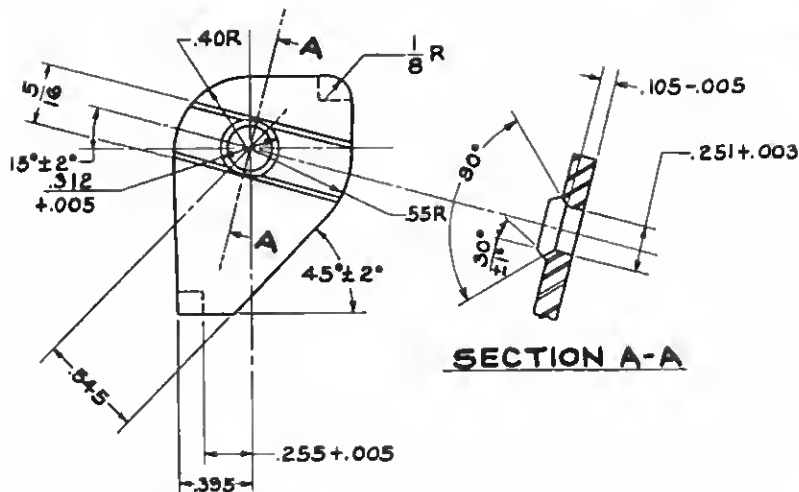
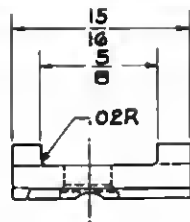
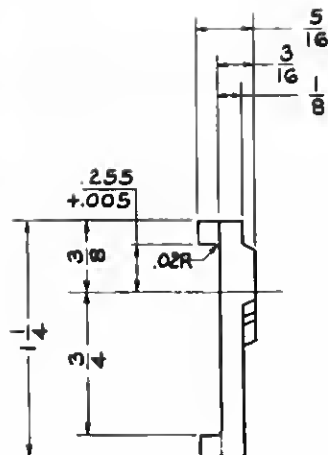
TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: $\frac{1}{64}$
ANGULAR: 5°

DESIGNED BY: F.J.C. TRUCE: M.C. L.S. DESIGNED BY:
CHECKED BY: GA. CHIEF DRAFTSMAN

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter C. Akerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



SECTION A-A

PLATE, FIXED
STEEL F54615
FINISH $\sqrt{125}$

6008822

WAS 88822

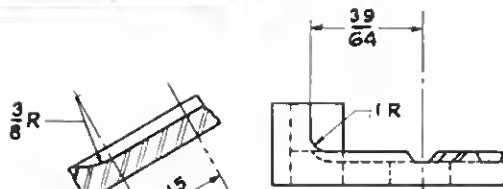
SCALE $\frac{2}{1}$

B 6008822

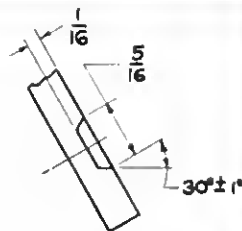
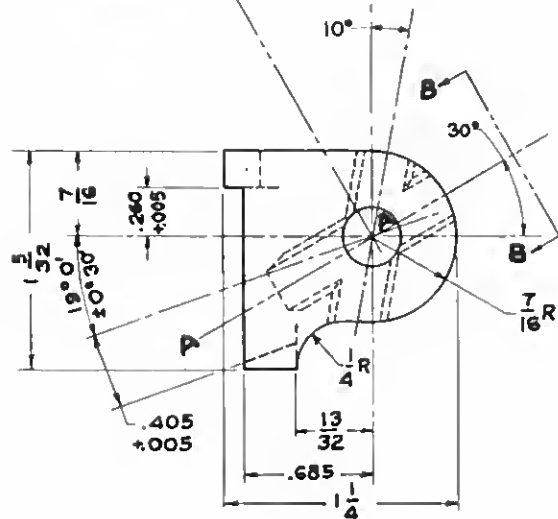
B6008822

HEAT TREATMENT AND FINAL FINISH

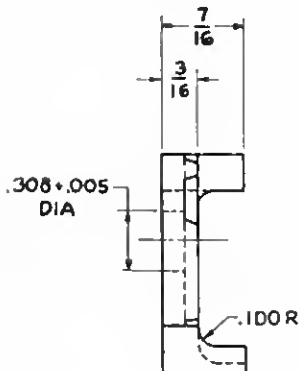
HEAT TREAT
TYPE II FINISH, CLASS B



SECTION A-A



VIEW B-B



PLATE, MOVABLE
STEEL FS 4615
FINISH 125/

R.I.A. FORGING SHOWN ON A7101648

WAS B8823

SCALE $\frac{2}{1}$

B 6008823

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL 2

RED

BR.

ACER

SCL

C. C.

0.018 TO 0.025
DEEP

SEPT. 23, 1932

REVISIONS

15 5-10-48

DRG. PERTAINS TO

B6008751 30 BMG
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 2°

DESIGNED J. C.	TRACED O.K.	CHECKED S.A.
APPROVED H. H. Roe		CHIEF DRAFTSMAN

SUBMITTED:
H. H. Roe
ORD. DEPT., U. S. A.

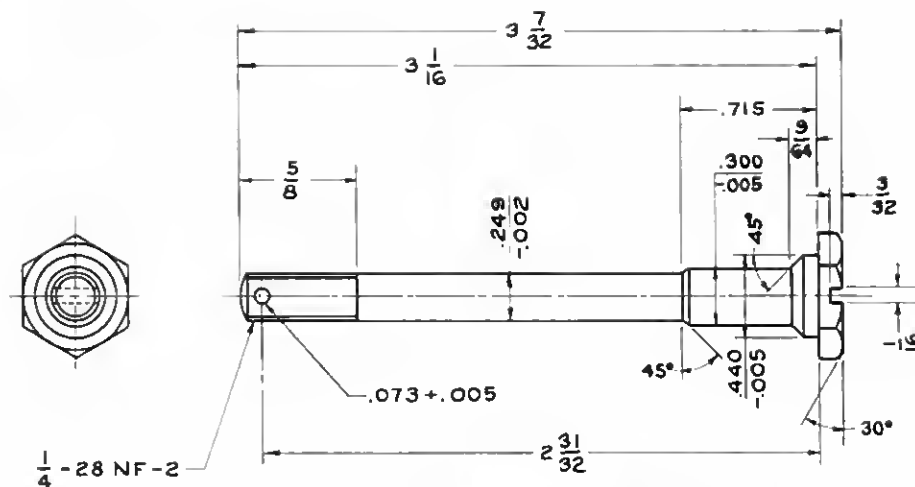
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter C. Ashmun
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6008823

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS BBOLT, COVER
STEEL FS 4140
FINISH 125

6008824

PHYSICAL
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	40-45
SCL.	

SEPT. 23, 1932

REVISIONS

12	5-10-48	

DRG. PERTAINS TO

6008757 .30 BMG
M19A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: $\frac{1}{64}$
ANGULAR: 5°

DESIGNED T.J.C.	TRACED O.K.	1/4 & 3/16
CHECKED M.E.	6.0	CHIEF DRAFTSMAN

SUBMITTED:

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B 8824

SCALE $\frac{2}{1}$

B 6008824

B6008824

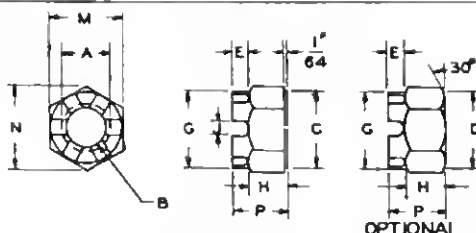
NUT, CASTLE, NF, SEMI-FINISHED, LIGHT

BBFXI

ORDNANCE DEPT. STANDARDS (COMMERCIAL)

H-34
APPROVED 7-14-31
DATE

NOTE:
ROUND OR SQUARE
BOTTOM IN SLOTS
OPTIONAL



DIAMETER, NOMINAL A MAJOR THD. DIAM.		#10 MIN.	1/4 .2500	5/16 .3125	3/8 .3750	7/16 .4375	1/2 .5000		
B THREADS PER INCH		32	28	24	24	20	20		
M WIDTH ACROSS FLATS	NOM.	3/8	7/16	1/2	9/16	5/8	3/4		
	MAX.	.3750	.4375	.5000	.5625	.6250	.7500		
N ACROSS CORNERS	MIN.	.365	.428	.489	.551	.612	.736		
	MAX.	.416	.488	.557	.628	.698	.840		
P THICKNESS		NOM.	1/4	9/32	21/64	13/32	29/64	9/16	
	MAX.	.266	.288	.336	.415	.475	.563	.673	
	MIN.	.234	.274	.320	.398	.444	.552		
H HEIGHT OF FLATS		NOM.	.110	3/16	15/64	9/32	19/64	13/32	
J WIDTH OF SLOT			5/64	5/32	3/32	1/8	1/8	5/32	
E DEPTH OF SLOT			5/32	3/32	3/32	1/8	5/32	5/32	
G DIAMETER OF CYLINDRICAL PART		MAX.	.231	.4375	.5000	.5625	.6250	.7500	
	MIN.	.211	.371	.425	.478	.531	.583	.637	
MATERIAL AND FINISH		ORDNANCE PART NUMBER, NF-2							
STEEL, COMMERCIAL									
PLAIN FINISH			103043	103044	103045	103046	103047		
CADIUM OR ZINC PLATED			125013	125020	125027	125035	125043		
PHOSPHATE COATED			125016	125024	131807	131802	131803		
STEEL, ALLOY									
PLAIN FINISH			218595	218596	218597	218598	218599		
CADIUM OR ZINC PLATED			432697	432709	432711	432744	432744		
PHOSPHATE COATED			571221	571222	571223	571224	571225		
MATERIAL AND FINISH		ORDNANCE PART NUMBER, NF-3							
STEEL, COMMERCIAL									
PLAIN FINISH		503204							
CADIUM OR ZINC PLATED			122498	122515	122531				
PHOSPHATE COATED									

MATERIAL:

STEEL, COMMERCIAL, MIN. ROCKWELL HARDNESS B-78.
STEEL, ALLOY - MIN. YIELD STRENGTH 130,000 P.S.I.

EXAMPLE FOR ORDERING: NUT, CASTLE, S-FIN., S., LIGHT, 1/2"-20NF-2, DRG. BBFXI, PART NO. 103047, PLAIN.

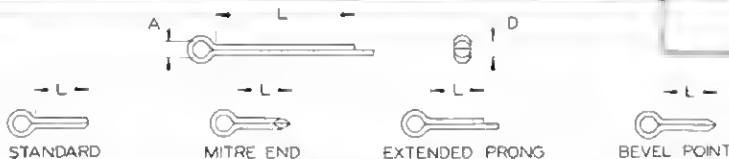
NOTE: ALLOY STEEL NUTS SHALL BE STAMPED WITH THE LETTER H ON ONE SIDE OF THE HEXAGON.

NOTE: DIAMETER OF WASHER FACE C = M MAX. -5%. DIAMETER OF BOTTOM CIRCLE D = M MAX. -15%.

REFERENCE: A.S.A. B18.2-1941.

DIMENSIONS IN INCHES.

BFAXI



OPTIONAL DESIGNS

D	COTTER PIN	NO. MAX. DIAMETER MIN.	1/16 .063 .095	3/32 .092 .064	7/64 .103 .100	1/8 .121 .113	5/32 .152 .144	
A	EYE DIAMETER		1/16	3/32	7/64	1/8	5/32	
L	LENGTH	ORDNANCE PART NUMBER, STEEL, PLAIN FINISH						
5/16	137124							
3/8	112526							
7/16	137130	112527						
1/2	103361	103372	192422	103383	103384			
5/8	107761	107762	192473	107763	107764			
3/4	103362	103373	141405	103385	103386			
7/8	100638	100639	141406	100640	100641			
1	103363	103374	121673	103387	103388			
1-1/8	100634	100635		103389	103390			
1-1/4	103364	103375		103391	103392			
1-3/8	100640	100641		100642	100643			
1-1/2	103365	103376	143722	103393	103394			
1-5/8	119207	119208		119209	119210			
1-3/4	106366	103377		103395	103396			
1-7/8	119176	119177		119178	119179			
2	103367	103378		103397	103400			
2-1/8	119211	119212	119217	443735	119166			
2-1/4	103368	103379		103398	103401			
2-1/2	103369	103380		103399	103402			
2-3/4	103370	103381		103403	103404			
3	103371	103382		103405	103406			
3-1/4		431614		120466	431624			
3-1/2				121221				
3-3/4					107319			
4					500747			
L	LENGTH	ORDNANCE PART NUMBER, STEEL, PLATED*						
5/16	137127							
3/8	137128							
7/16	137133							
1/2	112726	119117						
5/8	137141	137155						
3/4	121223	121222						
7/8	127150	137163						
1	175252	121224						
1-1/8	107543	137175						
1-1/4		119120						
1-3/8								
1-1/2	107357							
1-5/8								
1-3/4		150777						
2								
2-1/4								
3-1/4								
L	LENGTH	ORDNANCE PART NUMBER, STEEL, OXIDE LEAKS ***						
5/8	544141							
L	LENGTH	ORDNANCE PART NUMBER, COR-RES-STEEL ****						
3/4	102736	120257						
3/8	193003							
1/2	190432	432254						
1-1/4	192742							
1-3/4		190301						

SPECIFICATIONS: COTTER PINS SHALL BE IN ACCORDANCE WITH FED. SPEC. FF-P-336 OF LATEST REVISION.

FINISH: *PLATED COTTER PINS MAY BE GALVALUM, ZINC OR BRIGHT NICKEL PLATED.

***PHOSPHATE COATING SHALL BE IN ACCORDANCE WITH TYPE II, CLASS B OF SPEC 57-0-2 OF LATEST REVISION.

****OXIDE COATING SHALL BE IN ACCORDANCE WITH TYPE III, CLASS A, GRADE I OF SPEC 57-0-2 OF LATEST REVISION.

NOMENCLATURE PATTERNS: PIN, COTTER, SPLIT, 1/16 x 7/16, STEEL, PLAIN FINISH, ENG. BFAXI, PART NO. 137130.

REVISIONS				ORIGINAL DATE OF DRAWING SEP 5, 1928		ORDNANCE ENGINEERING STANDARDS (COMMERCIAL)	ORDNANCE DEPT DEPT OF THE ARMY
SYM	DESCRIPTION	DATE	APPRO	DRAFTSMAN	CHECKER		
17		5-23-49	W.C.K.	TYPIST D.C.H.	CHECKER P.M.M.		
18		10-14-49		ENGINEER H. E. Rogers	ENGINEER		
				SUBMITTED O. Kendall	APPROVED G. S. Stamp	PIN. COTTER. SPLIT	ENGINEERING & INSPECTION SECTION - ORDIP PREPARED BY ROCK ISLAND ARSENAL
				MATERIAL			
				COMMERCIAL AS SPECIFIED			
				SCALE			
				DIMENSIONS IN INCHES		BFAXI	

FINISH TYPE II, CLASS B

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		15	5-10-46
Y. S.		16	6-21-49
EL. #			
RED			
BR.			
ROCK			
SCL.			

DRG. PERTAINS TO

05364056	M19A4 (FXD)
	M19A4 (FLEX)
	M19A5 (FXD)
	M19A6

COVER-D7116476

100.00

ALTERNATIVE A

PLATE - A 5020505
RIVET - A 5020513

RIVET AND
FILE FLUSH

- RIVET-A 7139165 (RIVET AND FILE FLUSH)
- CAM-B6017494
- RIVET-A 7139164 (RIVET AND FILE FLUSH)

COVER, ASSEMBLY

(509801)

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL 2 —
FRACTIONAL $\frac{1}{2}$ —
ANGULAR $0^{\circ} 00'$

1000

W. B. R.

CLARIFIED

SUBMITTED:

140

1000

1997, 1998, 1999, 2000, 2001, 2002, 2003, 2004, 2005, 2006, 2007, 2008, 2009, 2010, 2011, 2012, 2013, 2014, 2015, 2016, 2017, 2018, 2019, 2020, 2021, 2022, 2023, 2024, 2025, 2026, 2027, 2028, 2029, 2030, 2031, 2032, 2033, 2034, 2035, 2036, 2037, 2038, 2039, 2040, 2041, 2042, 2043, 2044, 2045, 2046, 2047, 2048, 2049, 2050, 2051, 2052, 2053, 2054, 2055, 2056, 2057, 2058, 2059, 2060, 2061, 2062, 2063, 2064, 2065, 2066, 2067, 2068, 2069, 2070, 2071, 2072, 2073, 2074, 2075, 2076, 2077, 2078, 2079, 2080, 2081, 2082, 2083, 2084, 2085, 2086, 2087, 2088, 2089, 2090, 2091, 2092, 2093, 2094, 2095, 2096, 2097, 2098, 2099, 2100, 2101, 2102, 2103, 2104, 2105, 2106, 2107, 2108, 2109, 2110, 2111, 2112, 2113, 2114, 2115, 2116, 2117, 2118, 2119, 2120, 2121, 2122, 2123, 2124, 2125, 2126, 2127, 2128, 2129, 2130, 2131, 2132, 2133, 2134, 2135, 2136, 2137, 2138, 2139, 2140, 2141, 2142, 2143, 2144, 2145, 2146, 2147, 2148, 2149, 2150, 2151, 2152, 2153, 2154, 2155, 2156, 2157, 2158, 2159, 2160, 2161, 2162, 2163, 2164, 2165, 2166, 2167, 2168, 2169, 2170, 2171, 2172, 2173, 2174, 2175, 2176, 2177, 2178, 2179, 2180, 2181, 2182, 2183, 2184, 2185, 2186, 2187, 2188, 2189, 2190, 2191, 2192, 2193, 2194, 2195, 2196, 2197, 2198, 2199, 2200, 2201, 2202, 2203, 2204, 2205, 2206, 2207, 2208, 2209, 2210, 2211, 2212, 2213, 2214, 2215, 2216, 2217, 2218, 2219, 2220, 2221, 2222, 2223, 2224, 2225, 2226, 2227, 2228, 2229, 2230, 2231, 2232, 2233, 2234, 2235, 2236, 2237, 2238, 2239, 2240, 2241, 2242, 2243, 2244, 2245, 2246, 2247, 2248, 2249, 2250, 2251, 2252, 2253, 2254, 2255, 2256, 2257, 2258, 2259, 2260, 2261, 2262, 2263, 2264, 2265, 2266, 2267, 2268, 2269, 2270, 2271, 2272, 2273, 2274, 2275, 2276, 2277, 2278, 2279, 2280, 2281, 2282, 2283, 2284, 2285, 2286, 2287, 2288, 2289, 2290, 2291, 2292, 2293, 2294, 2295, 2296, 2297, 2298, 2299, 2300, 2301, 2302, 2303, 2304, 2305, 2306, 2307, 2308, 2309, 2310, 2311, 2312, 2313, 2314, 2315, 2316, 2317, 2318, 2319, 2320, 2321, 2322, 2323, 2324, 2325, 2326, 2327, 2328, 2329, 2330, 2331, 2332, 2333, 2334, 2335, 2336, 2337, 2338, 2339, 2340, 2341, 2342, 2343, 2344, 2345, 2346, 2347, 2348, 2349, 2350, 2351, 2352, 2353, 2354, 2355, 2356, 2357, 2358, 2359, 2360, 2361, 2362, 2363, 2364, 2365, 2366, 2367, 2368, 2369, 2370, 2371, 2372, 2373, 2374, 2375, 2376, 2377, 2378, 2379, 2380, 2381, 2382, 2383, 2384, 2385, 2386, 2387, 2388, 2389, 2390, 2391, 2392, 2393, 2394, 2395, 2396, 2397, 2398, 2399, 2400, 2401, 2402, 2403, 2404, 2405, 2406, 2407, 2408, 2409, 2410, 2411, 2412, 2413, 2414, 2415, 2416, 2417, 2418, 2419, 2420, 2421, 2422, 2423, 2424, 2425, 2426, 2427, 2428, 2429, 2430, 2431, 2432, 2433, 2434, 2435, 2436, 2437, 2438, 2439, 2440, 2441, 2442, 2443, 2444, 2445, 2446, 2447, 2448, 2449, 2450, 2451, 2452, 2453, 2454, 2455, 2456, 2457, 2458, 2459, 2460, 2461, 2462, 2463, 2464, 2465, 2466, 2467, 2468, 2469, 2470, 2471, 2472, 2473, 2474, 2475, 2476, 2477, 2478, 2479, 2480, 2481, 2482, 2483, 2484, 2485, 2486, 2487, 2488, 2489, 2490, 2491, 2492, 2493, 2494, 2495, 2496, 2497, 2498, 2499, 2500, 2501, 2502, 2503, 2504, 2505, 2506, 2507, 2508, 2509, 2510, 2511, 2512, 2513, 2514, 2515, 2516, 2517, 2518, 2519, 2520, 2521, 2522, 2523, 2524, 2525, 2526, 2527, 2528, 2529, 2530, 2531, 2532, 2533, 2534, 2535, 2536, 2537, 2538, 2539, 2540, 2541, 2542, 2543, 2544, 2545, 2546, 2547, 2548, 2549, 2550, 2551, 2552, 2553, 2554, 2555, 2556, 2557, 2558, 2559, 2560, 2561, 2562, 2563, 2564, 2565, 2566, 2567, 2568, 2569, 2570, 2571, 2572, 2573, 2574, 2575, 2576, 2577, 2578, 2579, 2580, 2581, 2582, 2583, 2584, 2585, 2586, 2587, 2588, 2589, 2590, 2591, 2592, 2593, 2594, 2595, 2596, 2597, 2598, 2599, 2600, 2601, 2602, 2603, 2604, 2605, 2606, 2607, 2608, 2609, 2610, 2611, 2612, 2613, 2614, 2615, 2616, 2617, 2618, 2619, 2620, 2621, 2622, 2623, 2624, 2625, 2626, 2627, 2628, 2629, 2630, 2631, 2632, 2633, 2634, 2635, 2636, 2637, 2638, 2639, 2640, 2641, 2642, 2643, 2644, 2645, 2646, 2647, 2648, 2649, 2650, 2651, 2652, 2653, 2654, 2655, 2656, 2657, 2658, 2659, 2660, 2661, 2662, 2663, 2664, 2665, 2666, 2667, 2668, 2669, 2670, 2671, 2672, 2673, 2674, 2675, 2676, 2677, 2678, 26

ADDRESS OF THE DONOR OF THE BOOK

OF DISTANCE.

✓ 5. 3. 4

Table 2

2025 RELEASE UNDER E.O. 14176

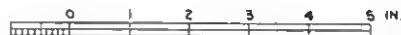
ORDNANCE DEPT., U. S. A.

[illegible]

Table 1. *Table 1. Selected Physical Characteristics of the Study Population*

WA5 C9801

65509801



HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A5020503

APRIL 4, 1927

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

C43-49

REVISIONS

14 5-10-48

DRG. PERTAINS TO

51-114-5

30 BMG
M19A5(FXD)

51-125-5

30 BMG
M19A6

51-10-45

30 BMG
M17A1(WC)

51-83-5

30 BMG
M19A4(FXD)

51-84-5

30 BMG
M19A4(FLEX)INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± —

FRACTIONAL : 1/64

ANGULAR : 5°

DRAFTSMAN

M.E.B.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKER

L.S.C.

CHIEF DRAFTSMAN

SUBMITTED:

A.W. Roe

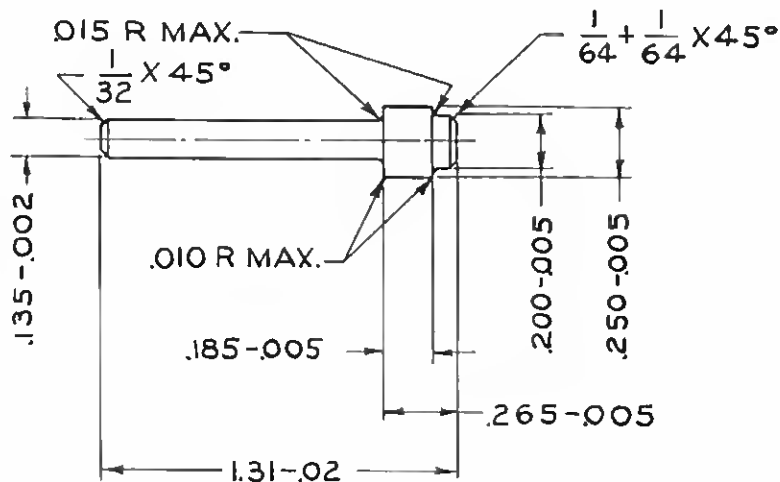
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



PIN, TRIGGER

STEEL FS4140

FINISH 125/

5020503

SCALE $\frac{2}{1}$

WAS A20503

A

5020503

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A5020513

APRIL 4, 1927

REVISIONS

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

11 5-10-48

DRG. PERTAINS TO

ORDNANCE DIVISIONAL
STANDARDINSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\frac{1}{16}$
ANGULAR $\pm 5^\circ$ DRAFTSMAN
W.C.O.TRACER
E.B.

L'D'G DRAFTSMAN

CHECKER
W.C.O.

g.o.

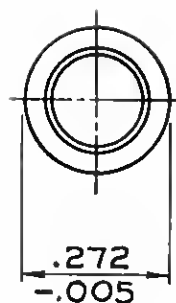
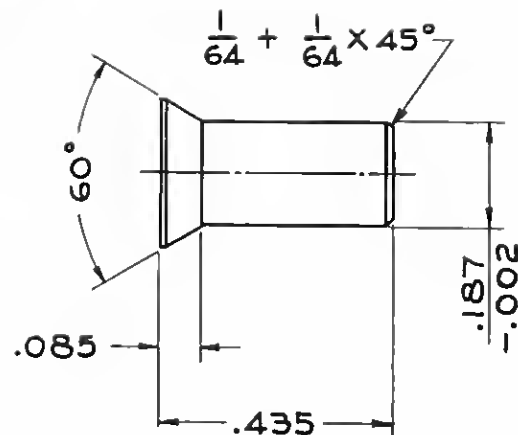
CHIEF DRAFTSMAN

SUBMITTED:

*A.H. Roe*APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



RIVET
STEEL FS 1035
FINISH $\frac{125}{V}$

5020513

WAS A20513

SCALE $\frac{4}{1}$

A 5020513

A7123315

MAY 25, 1945

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

SCL.

T. S.

BR.

E. L. 2

ROCK

REVISIONS

1 5-10-48

DRG. PERTAINS TO

C5509814

30 B.M.G.
M17A1 (WC)

C5509801

30 B.M.G.
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS

NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

W.O.F.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKER

H.W.J.

CHIEF DRAFTSMAN

SUBMITTED:

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter C. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

SCL.

T. S.

BR.

E. L. 2

ROCK

REVISIONS

1 5-10-48

DRG. PERTAINS TO

C5509814

30 B.M.G.
M17A1 (WC)

C5509801

30 B.M.G.
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS

NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

W.O.F.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKER

H.W.J.

CHIEF DRAFTSMAN

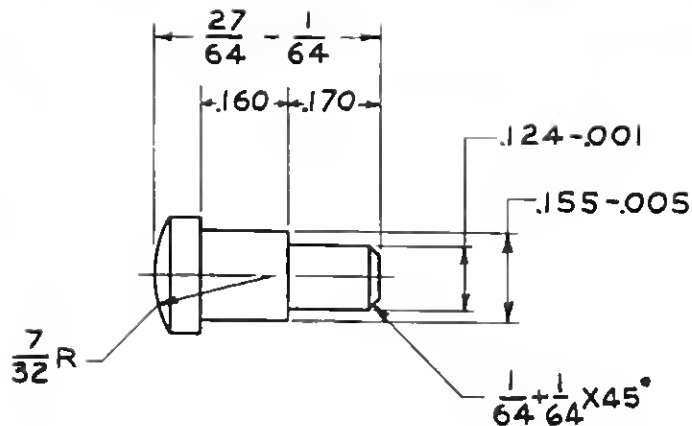
SUBMITTED:

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter C. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

STUD COVER EXTRACTOR SPRINGSTEEL FS1115FINISH $\frac{125}{\sqrt{}}$

7123315

SUPERSEDES A7123315 WQ/C 5-10-48

SCALE $\frac{4}{1}$

A 7123315

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A7133164

MAY 10, 1948

REVISIONS

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

DRG. PERTAINS TO

C5509801

30 BMG M19A4
(FXD) & (FLEX.)
M19A5 (FXD)
M19A6INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{64}$ ANGULAR $\pm 5'$

DRAFTSMAN

A.P.R.

TRACER

E.R.G.

L'D'G DRAFTSMAN

CHECKER

H.W.J.

CHIEF DRAFTSMAN

SUBMITTED:

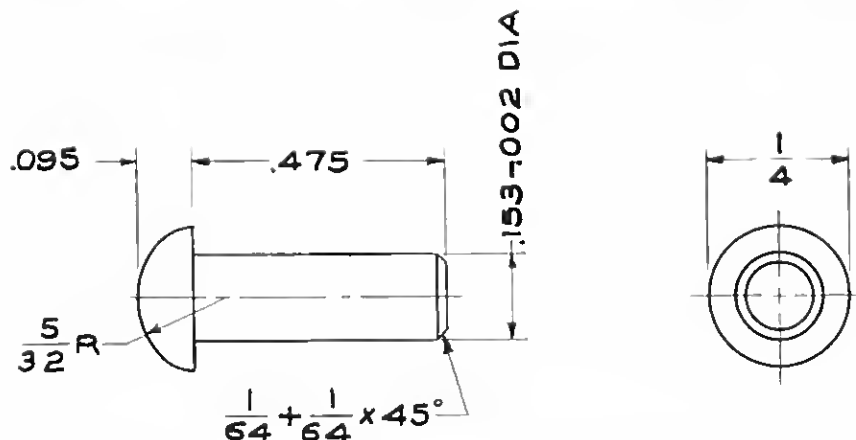
A.W. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Ackerman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**RIVET COVER EXTRACTOR CAM, LONG**STEEL FS 1035FINISH $\frac{125}{\sqrt{\quad}}$

7133164

SUPERSEDES A20511A WO/C 5-10-48

SCALE $\frac{4}{1}$

A 7133164

MADE AT ROCK ISLAND ARSENAL

A7133165

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MAY 10, 1948

Y. P.

RED.

SCL.

T. S.

BR.

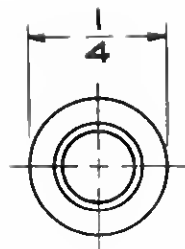
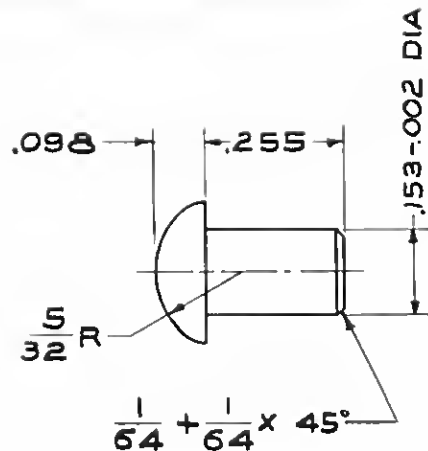
EL. 2

ROCK

REVISIONS

DRG. PERTAINS TO

C5509801

308MG M19A4
(FXD) & (FLEX.)
M19A5 (FXD)
M19A6RIVET, COVER EXTRACTOR CAM, SHORTSTEEL FS1035

FINISH 125

7133165

~~DO~~

DO NOT INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± .005

FRACTIONAL 1/64

ANGULAR 5°

DRAFTSMAN

A.P.R.

TRACER

E.R.G.

L'D G DRAFTSMAN

CHECKER

H.W. Ford

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT. U.S.A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT. U.S.A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES A20512A W/O/C 5-10-48

SCALE 4/1

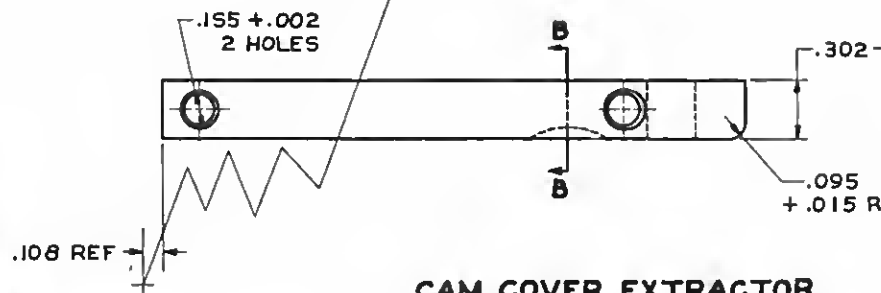
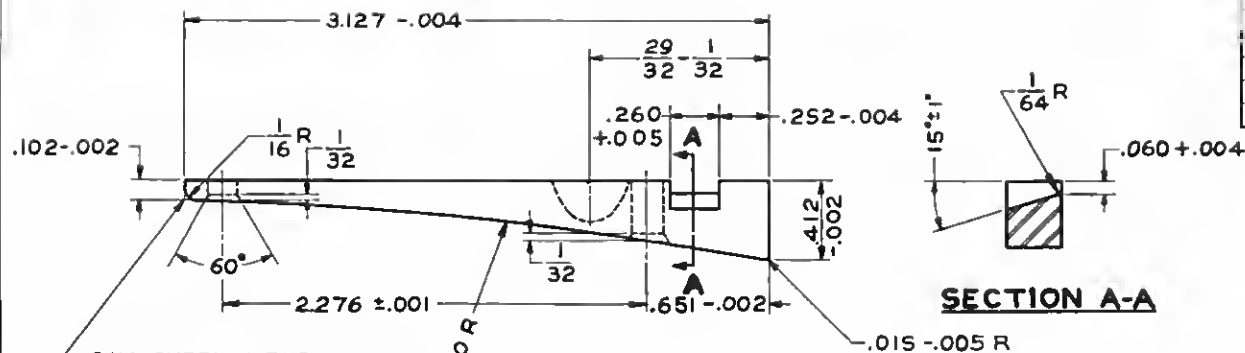
A

7133165

MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT AND FINAL FINISH

CARBON CASE .010 TO .015 DEEP.
ANNEAL ONE HALF INCH OF SMALL END.



CAM, COVER EXTRACTOR

STEEL FS461S

FINISH 125

6017494

SCALE $\frac{2}{1}$

WAS B17494

B 6017494

PHYSICAL PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A78-83
SCL.	

APRIL 4, 1927

REVISIONS

16	5-10-48	

DRG. PERTAINS TO

C5509814	.30 BMG M17A1(WC)
C5509801	.30 BMG M19A4(FXD) M19A4(FLEX) M19A5(FXD) M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: 1/64
ANGULAR: 5°

DESIGNED R.A.	TRACED L.R.E.	1/4" DIA. BRASS S.S.
CHECKED J.H.	APPROVED S.A.	CHIEF DRAFTSMAN

SUBMITTED:

F.H. Roe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6017494

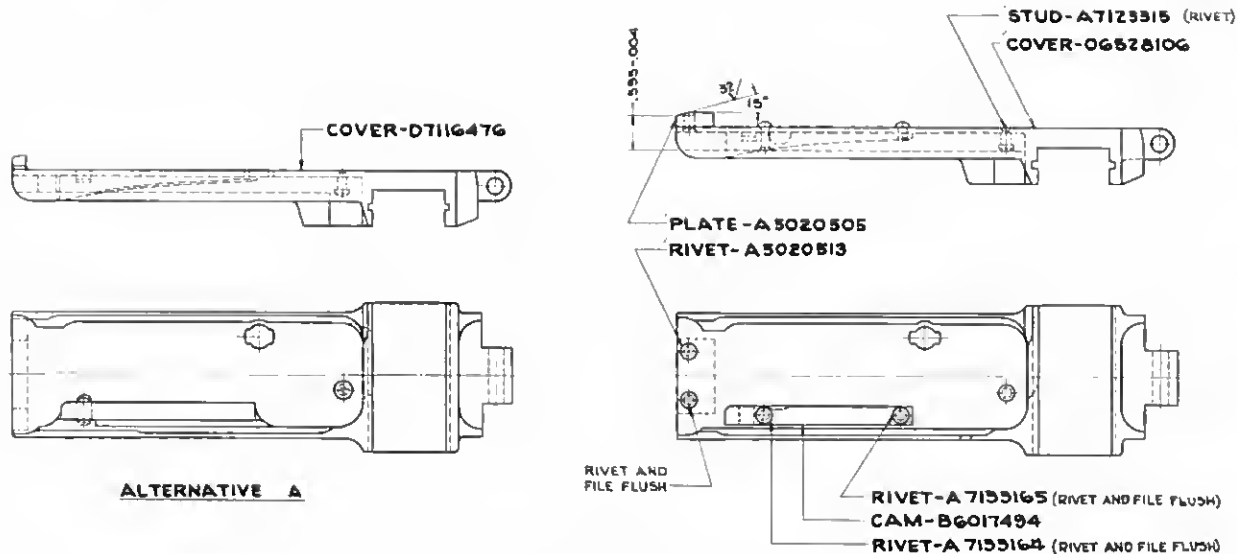
HEAT TREATMENT AND FINAL FINISH

FINISH TYPE II, CLASS B

PHYSICAL PROPERTIES	JUNE 1, 1931	
	REVISIONS	
Y. P.	15	540-40
T. S.	16	21-49
EL. S.		
RED.		
BR.		
POCK.		
SCL.		

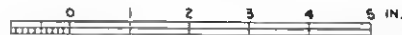
DRG. PERTAINS TO

5564056
MISAA (FES)
MISAA (FES)
MISAA (FES)
MISAA



COVER, ASSEMBLY

5509801



WAS C9801

5509801

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL 2 —
FRACTIONAL 1 —
ANGULAR 1/2° 3/4°

W.D.H. *[Signature]*

DATE *[Signature]*

SUBMITTED

[Signature]

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

[Signature]

ORDNANCE DEPT., U. S. A.

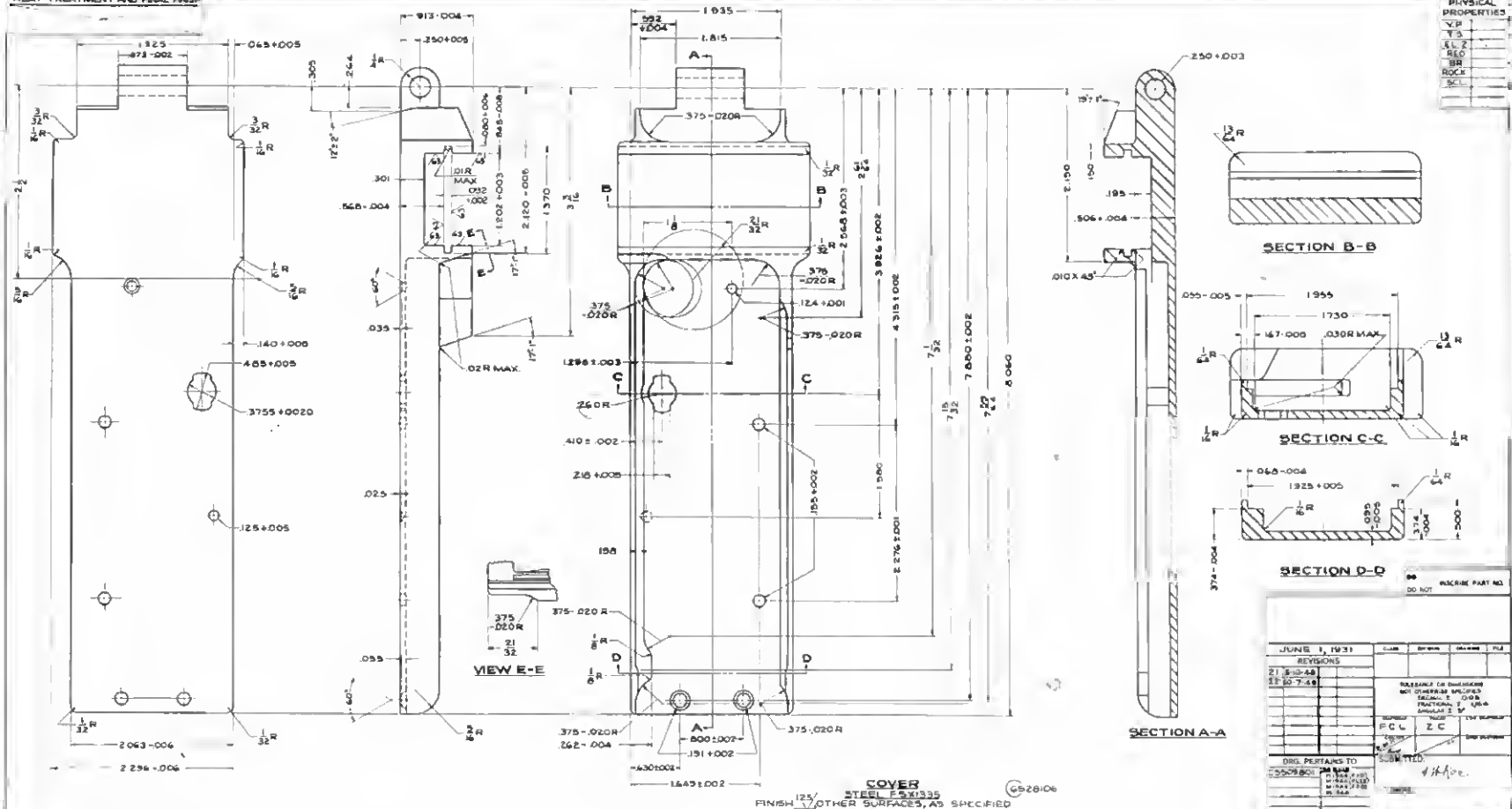
MADE AT ROYAL TOWN, ENGLAND

C5509801

HEAT TREATMENT AND FINAL FINISH:

PHYSICAL PROPERTIES
YR
Y3
LL 2
REO
BR
ROCK
SC

00162530



RIA FORGING SHOWN ON DRG C76071

COVER
STEEL 15-7-35
FINISH OTHER SURFACES, AS SPECIFIED

6528106

WAS D26/06

SCALE 2/1

JUNE 1, 1931		CLASS	REVISED	FILE
REVISIONS				
21	5-10-48			
22	10-7-48			
DESIGNED BY		CHECKED BY		
DRAWN BY		APPROVED BY		
IN CHARGE		DATE		
MATERIAL		QUANTITY		
FINISH		TOLERANCES		
STANDARD		SPECIFICATION		
DRAWN BY		CHECKED BY		
IN CHARGE		APPROVED BY		
MATERIAL		QUANTITY		
FINISH		TOLERANCES		
STANDARD		SPECIFICATION		

D/6528106

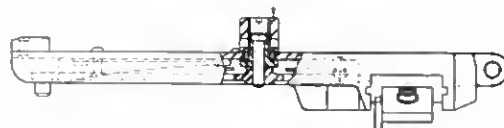
ORDNANCE DEPT. U.S.A.

PHYSICAL PROPERTIES		SEPTEMBER 30, 1936	
		REVISIONS	
Y P		12	5-10-48
T S		13	6-21-49
EL 1			
RED			
BR			
ROCK			
SCL			

DRG PERTAINS TO

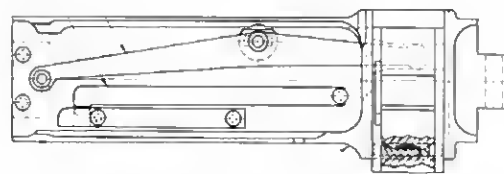
51-83-1	HAZ (FS)
51-84-1	NO 8 MG
51-114-1	AA (FL)
51-125-1	8 (FAD)
	NO 8 MG

★PIVOT, ASSEMBLY-BG110529



LEVER-BG017503

SPRING-BG017513



★ COVER, ASSEMBLY-C 5509801

SPRING-BG147224

★SLIDE, ASSEMBLY-BG131262

★PIN, ASSEMBLY-BG131255

PAWL-C5508461

★ FINDING DIAGRAM

INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL —
FRACTIONAL —
ANGULAR —DESIGNED BY *CFD* CHECKED BY *CFD* DRAWN BY *CFD*ENGINEER *CFD* PROJECT ENGINEER *CFD*

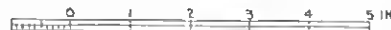
SUBMITTED

*4/11/40*APPROVED BY ORDER OF *WAS* CHIEF OF ORDNANCE*WAS* CHIEF OF ORDNANCE

ORDNANCE DEPT., U. S. A.

MADE AT BULK HEAD ASSEMBLY

COVER, BELT FEED ASSEMBLY 5564096



WAS 5564096

5564096

C 5564096

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS BPHYSICAL
PROPERTIESY. P.
T. S.
EL. 2
RED
BR.
RC 44
SCL

APRIL 4, 1927

REVISIONS

205-10-48

DRG. PERTAINS TO

C5509177 M17A1(WC)
30 BMQ
C5564096 M19A4(FXD)
M19A4(FLEX)
M19AS(FXD)
M19AG

DO

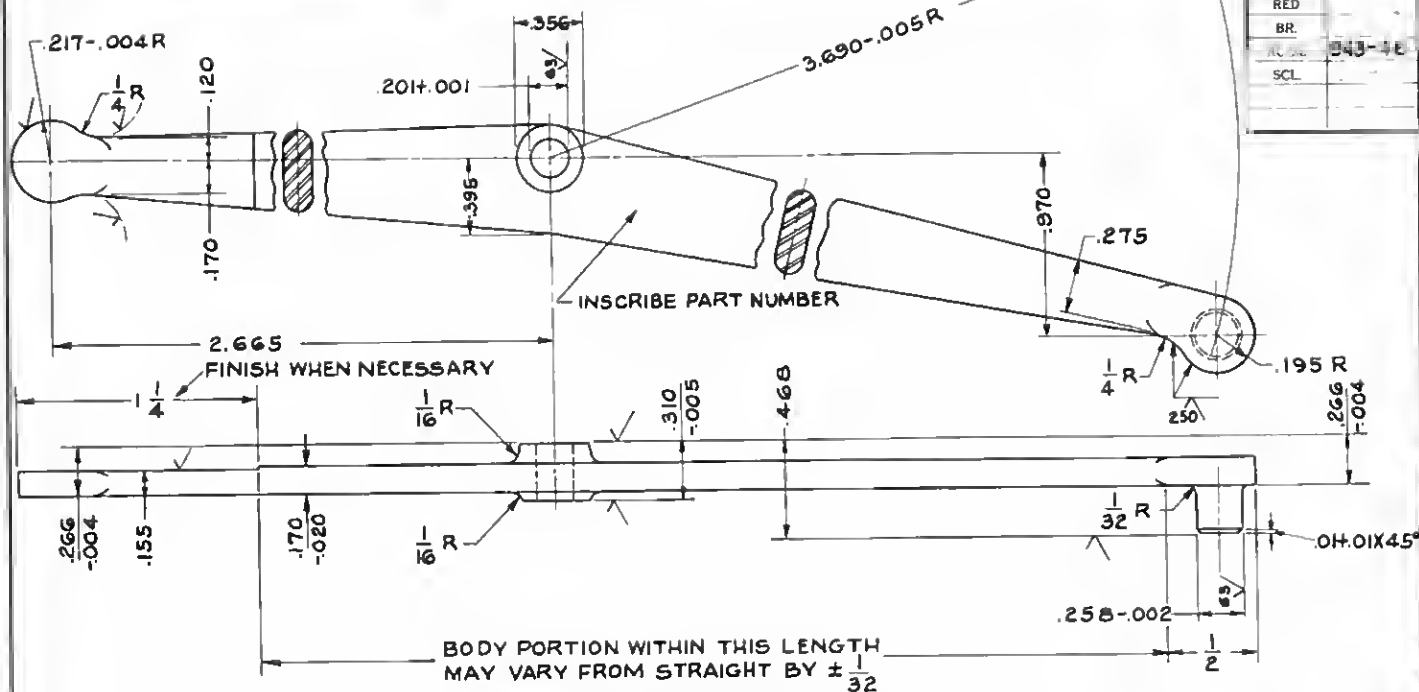
INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 5°F.H.M. T.E.C. L.V.C. DUFFYMAN
M.C. C.H.E.F. DUFFYMAN

SUBMITTED:

A.H. Roe
ORD. DEPT. U. S. A.APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:Walter C. Cushman
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

**LEVER, FEED, BELT** (6017503)
STEEL F54140FINISH $\sqrt{}$ TO BE $\sqrt{}$ 125, OTHER SURFACES,
AS SPECIFIED

R.I.A. FORGING SHOWN ON DRG A186415

WAS B17503

SCALE $\frac{2}{1}$

B 6017503

B6017503

HEAT TREAT
TYPE II FINISH, CLASS B

APRIL 4, 1927.

REVISIONS

SCL

A73-76

15 5-10-48

DRG. PERTAINS TO

C5509177

C556409

30 BMG
M17A1 (WC)
30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR \pm —

DRIFTMAN	TRACER	CODE DRIFTMAN
R.W.D.	E. B.	
DRIVER		CHIEF DRIFTMAN

SUBMITTED:

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:-

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

DEVELOPED LENGTH = 4½ APPRDX

SECTION A-A

SCALE $\frac{2}{1}$

SPRING COVER EXTRACTOR

SPRING STEEL WDI095

NO.18 (0478) U.S. GAGE THICK

FINISH 125

WA5 B17513

SCALE $\frac{1}{4}$ | B | 6017513

B6017513

DRAW AT 450°F.
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F.



DIAMETER OF WIRE	.032
TOTAL NUMBER OF COILS	6.
OUTSIDE DIAMETER, FREE	.340±.005
MAX. OUTSIDE DIA AT MIN OPERATING HEIGHT	.350
FREE LENGTH	.78±.03
TYPE OF ENDS	AS SHOWN
WOUND	R.H.
MEAN ASSEMBLED HEIGHT	.4
MIN LOAD AT MEAN ASSEMBLED HEIGHT	3.7 LB
MINIMUM OPERATING HEIGHT	.238
MIN LOAD AT MIN OPERATING HEIGHT	6.1 LB ± 1 LB
LB PER INCH OF SPRING DEFLECTION	9.73
SPRING FUNCTIONS IN HOLE	.357
SPRING FUNCTIONS OVER ROD	.156
CALCULATED MIN SOLID HEIGHT	.192

CAUTION: DO NOT COMPRESS SOLID NOTE:

5% OF SPRINGS WILL BE FATIGUE TESTED BETWEEN ASSEMBLED HEIGHT AND MINIMUM OPERATING HEIGHT FOR 25,000 CYCLES. THE LOAD AT ASSEMBLED HEIGHT, AFTER TESTING, SHOULD NOT BE LESS THAN 2.5 LB

SPRING, BELT FEED PAWL
SPRING STEEL WIRE WDI085 SPECIAL - CLASS A

6147224

WAS BI47224

SCALE $\frac{2}{1}$

B

614 7224

PHYSICAL PROPERTIES		FEBRUARY 1, 1938	
		REVISIONS	
Y. P.		12	5-10-48
T. S.			
EL. 2			
RED.			
BR.			
ROCK			
SCL.			
		DRC. PERTAINS TO	

DRG. PERTAINS TO

C5509177	30 BMG M17A1 (WC)
C5564096	30 BMG M19A4 (FXD)
	M19A4 (FLEX)
	M19A5 (FXD)
	M19A6

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL \pm —
ANGULAR \pm —

DRAFTSMAN W.L.M.	TRACER M.C.	LDG DRAFTSMAN
CHECKED W.L.M.		CHIEF DRAFTSMAN

SUBMITTED:

A.H. ROE

ORD OFF. 4 3 4

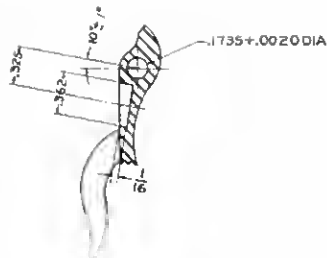
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Anderson

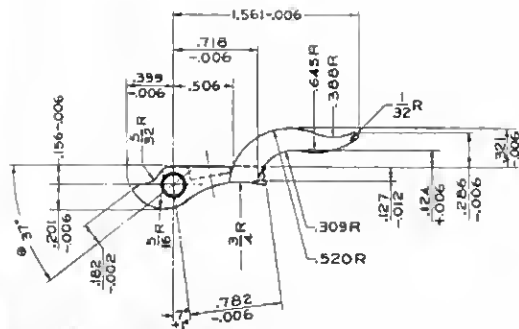
ORDNANCE DEPT., U. S. A.

B6147224

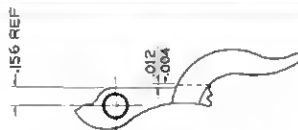
HEAT TREAT
TYPE II FINISH, CLASS B



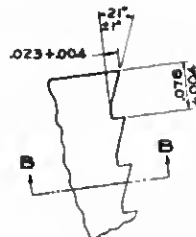
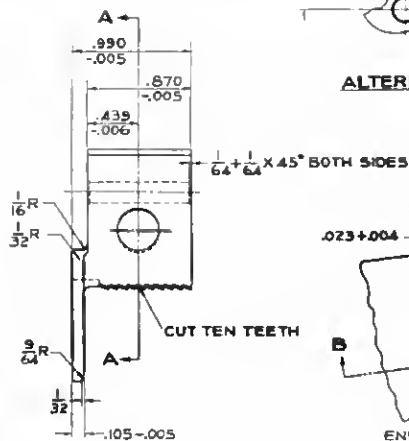
SECTION A-A



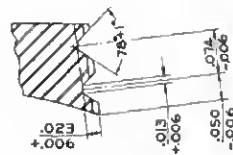
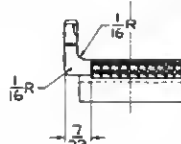
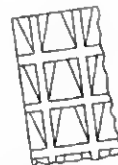
⑥ PERMISSIBLE ANGLE TOLERANCE NOT SPECIFIED, MUST BE WITHIN LIMITS PRESCRIBED BY LOCATING DIMENSIONS.



ALTERNATIVE DESIGN



ENLARGED VIEW OF SERRATIONS

SCALE $\frac{10}{T}$ 

SECTION B-B

SCALE $\frac{10}{1}$

PAWL FEED BELT (5508461)
STEEL F3.4140
FINISH 125/

WA5 C8461

DO NOT INCLUDE PART NO.

SCALE 2

1	5508461
---	---------

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISONS	
Y. P.		18	5-10-46
T. S.			
EL. #			
RED			
BM			
ROCK	C 62-58		
SC			
		DRG. PERTAINS TO	

DRG. PERTAINS TO

[illegible]

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL = .009
FRACTIONAL = 9/1000

DATE	DESCRIPTION	AMOUNT
1947-1-1
1947-1-2
1947-1-3
1947-1-4
1947-1-5
1947-1-6
1947-1-7
1947-1-8
1947-1-9
1947-1-10
1947-1-11
1947-1-12
1947-1-13
1947-1-14
1947-1-15
1947-1-16
1947-1-17
1947-1-18
1947-1-19
1947-1-20
1947-1-21
1947-1-22
1947-1-23
1947-1-24
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1947-1-26
1947-1-27
1947-1-28
1947-1-29
1947-1-30
1947-1-31
1947-2-1
1947-2-2
1947-2-3
1947-2-4
1947-2-5
1947-2-6
1947-2-7
1947-2-8
1947-2-9
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1947-2-11
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1947-2-29
1947-3-1
1947-3-2
1947-3-3
1947-3-4
1947-3-5
1947-3-6
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1947-3-27
1947-3-28
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1947-3-30
1947-3-31
1947-4-1
1947-4-2
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1947-4-19
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1947-4-21
1947-4-22
1947-4-23
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1947-4-28
1947-4-29
19		

SUBMITTED

A. H. Roe

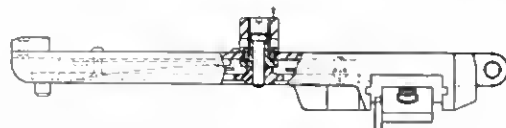
APPROVED BY ORDER OF THE COMPTROLLER
OF TREASURY.

OWO DEPT 12 2 2

Model AV Aircraft Engine Assembly

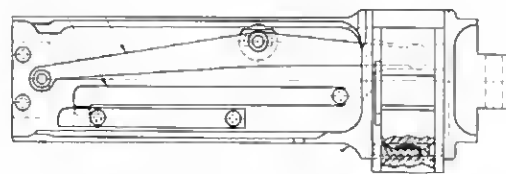
PHYSICAL PROPERTIES		SEPTEMBER 30, 1936	
		REVISIONS	
Y P		12	5-0-48
T S		13	6-21-49
EL 1			
RED			
BR			
ROCK			
SCL			

★PIVOT, ASSEMBLY-BG110529



LEVER-BG017503

SPRING-BG017513



SPRING-BG147224

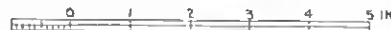
★SLIDE, ASSEMBLY-BG131262

★PIN, ASSEMBLY-BG131255

PAWL-C5508461

★ COVER, ASSEMBLY-C 5509801

COVER, BELT FEED ASSEMBLY 5564096



WAS CG4096

C5564096

DRG PERTAINS TO

51-83-1	RAA (FS)
51-84-1	RAA (FS)
51-114-1	RAA (FS)
51-125-1	RAA (FS)

★ FINDING DIAGRAM

INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL
FRACTIONAL
ANGULARC.F.D. *[Signature]* S.B. PROTECTSUBMITTED *[Signature]* S.B. PROTECTAPPROVED BY ORDER OF THE CHIEF
OF ORDNANCE*[Signature]* W.D. 2287 U.S.A.

ORDNANCE DEPT., U. S. A.

MADE AT PULASKI, MISSOURI

C 5564096

TYPE II FINISH, CLASS B

EXTENSION-06508259

STUD-A5024605

EXTENSION, BARREL, ASSEMBLY (5364139)

Y. P.		8 5-10-48	
Y. B.			
EL. 2			
RED			
BR			
ROCK			
SCL			

ORG. PERTAINS TO

51-10-1	30 BMG M1911 (WC)
51-83-1	30 BMG M1914 (F&D)
51-84-1	30 BMG M1914 (FLEX)
51-114-1	30 BMG M1913 (F&D)
51-125-1	30 BMG M1916

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL = .0005
FRACTIONAL = 1/32
ANGULAR = 1/4

77.7 E.R.G.

SUBMITTED:

44 Roe

APPROVED BY ORDER OF THE COMD

Matthew Anderson

ORDNANCE DEPT., U. S. A.

[illegible]

WAS C64139

DO NOT INSCRIBE PART NO

05564139

A horizontal scale bar with markings from 0 to 5 inches. The markings are labeled 0, 1, 2, 3, 4, and 5 IN. The bar is divided into five equal segments, each representing one inch.

A 5024605

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 1, 1931

HEAT TREAT

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

C 30-35

REVISIONS

11 5-10-48

DRG. PERTAINS TO

C5564139

30B MG
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

F.C.L.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.S.C.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

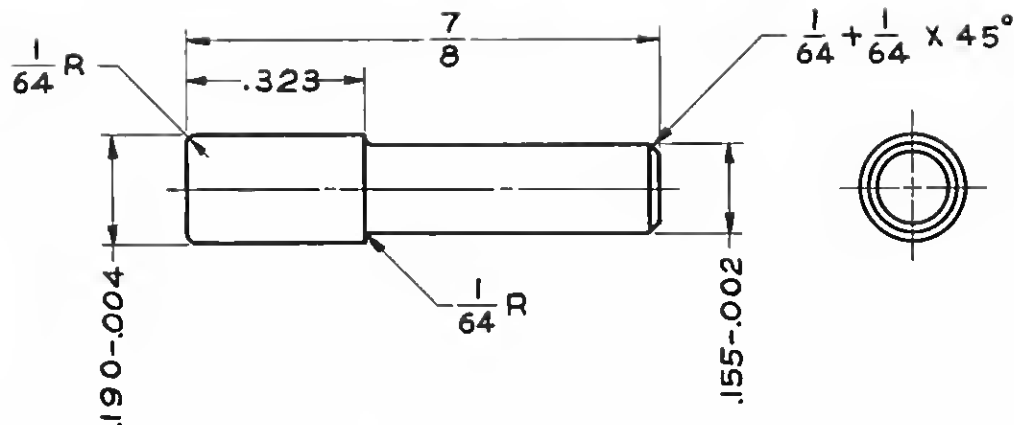
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**STUD, BARREL PLUNGER**

STEEL FS 1095

FINISH 125/

5024605

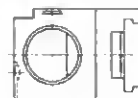
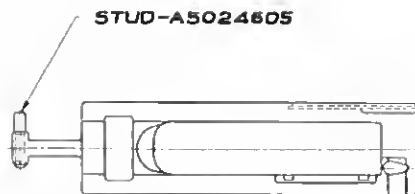
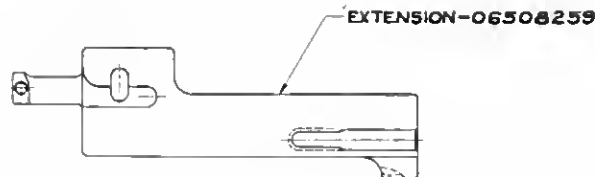
WAS A24605

SCALE $\frac{4}{1}$

A

5024605

HEAT TREATMENT AND FINAL FINISH
TYPE II FINISH, CLASS B



EXTENSION, BARREL ASSEMBLY C5564139

PHYSICAL PROPERTIES		FEB. 1, 1938 REVISIONS	
Y. P.		8	5-10-40
T. B.			
E. L. T.			
RED.			
BR.			
ROCK.			
SCL.			

ORG. PERTAINS TO	
51-10-1	30 BMG M17A1 (WG)
51-83-1	30 BMG M19A4 (F&D)
51-84-1	30 BMG M19A4 (F&D)
51-114-1	30 BMG M19A3 (F&D)
51-125-1	30 BMG M19A4

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMALS —
FRACTIONAL —
ANGULAR —

77 ERG

SUBMITTED:

4 H. Roe

APPROVED BY ORDER OF THE CHIEF
OF BUREAU.

ORDNANCE DEPT., U. S. A.

WAS C64139

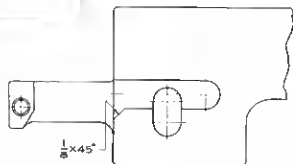
DO NOT INSCRIBE PART NO.

C5564139

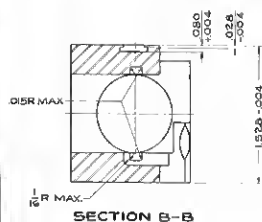


C5564139

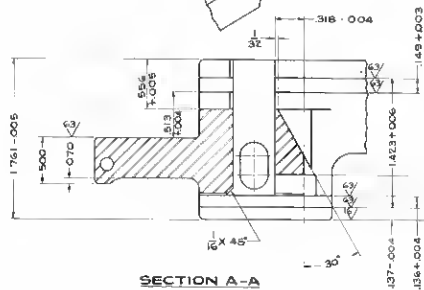
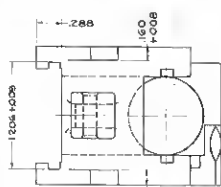
HEAT TREAT



ALTERNATIVE METHOD OF MANUFACTURE

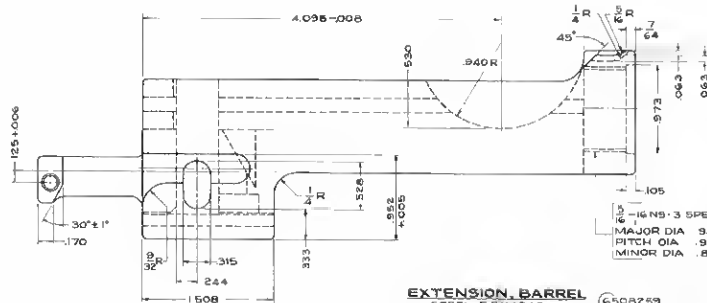
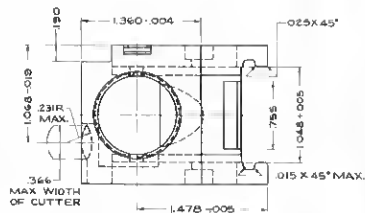
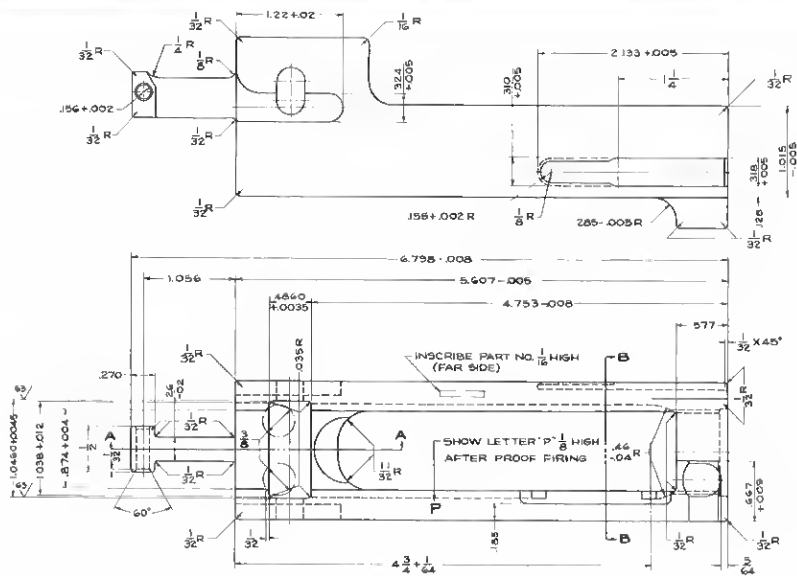


SECTION B-B



SECTION A-A

RIA FORGING SHOWN ON DRG C76070



EXTENSION, BARREL (6508259)
STEEL FBX4340

FINISH ¹²⁵✓ OTHER SURFACES, AS SPECIFIED

WAS DB259

SCALE 2

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL 2	
RED	
BR	
ROCK	C-45-5
SCL	

06508259

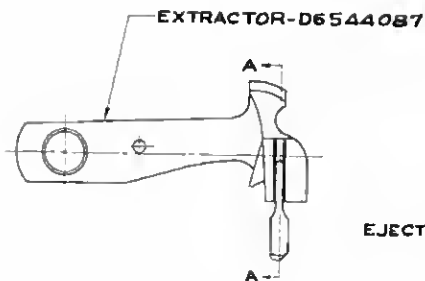
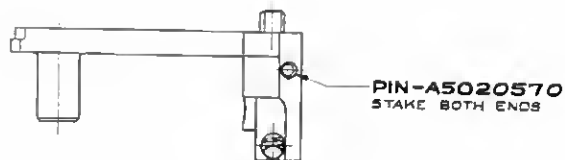
INSCRIBE PART NO.

APRIL 4, 1927	CLASS	SESSION	STANDARD	PAGE
REVISIONS				
33-15-10-65				
	TOLERANCE ON IMPROPER NOT CONSIDERED SPECIFIED ORIGINAL A GOOD PRACTICE D. 106			
	M E B	Z C	THEY SHOULD BE	
			NOT KNOWN	
URG. CERTAINS TO	SUBMITTED.			
5564139	<i>A.H. Fox</i>			
	EXAMINED			
	DO NOT USE			
	APPROVED BY ORDER OF THE CHIEF OF DIVISION			
	<i>Photo Acknowledged</i>			
	(ORD DEPT. U.S.A.)			
D 6508259	ORDNANCE DEPT., U.S.A.			

PHYSICAL PROPERTIES		OCTOBER 30, 1942	
		REVISIONS	
Y. P.		2	5-10-48
T. S.			
EL. &			
RED.			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

51-10-1	30 B MG	M 17A (VC)
51-23-1	30 B MG	M 19AA (FXD)
51-24-1	30 B MG	M 19AA (FLEX)
51-114-1	30 B MG	M 19A3 (FXD)
51-125-1	30 B MG	M 19A6



EJECTOR-B607497

SPRING-B6147228

PLUNGER-B62611DI

PIN-A5020570
STAKE BOTH ENDS

SECTION A-A

EXTRACTOR, ASSEMBLY (5621076)

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL: .0005

FRACTIONAL: 1/16

ANGULAR: .0005

SUBMITTED

SUBMITTED

SUBMITTED

SUBMITTED

SUBMITTED

SUBMITTED

SUBMITTED

SUBMITTED

WAS C121076

DO NOT INSCRIBE PART NO.

C5621076

APPROVED BY (UNLESS OTHERWISE SPECIFIED)

OF ORIGIN

ORDNANCE DEPT., U. S. A.

NAME & TITLE (UNLESS OTHERWISE SPECIFIED)







A 5020570

APRIL 4, 1927

HEAT TREATMENT & FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES

Y. P.		RED.		SCL.	
T. S.		BR.			
EL 2		ROCK	C38-43		

REVISIONS

14 5-10-48

DRG. PERTAINS TO

C5621076

30 BMO
M 17A1(WC)
M 19A4(FXD)
M 19A4(FLEX)
M 19A5(FXD)
M 19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL $\pm 1/64$
ANGULAR \pm —

DRAFTSMAN M.T.	TRACER L.R.E.	L'D'S DRAFTSMAN
CHECKER L.B.E.	C.C.	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

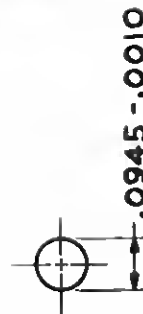
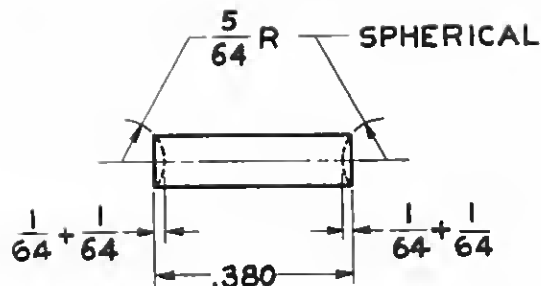
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



PIN
STEEL FS 1095
FINISH 125/

WAS A20570

SCALE 4/1

A 5020570

HEAT TREAT
TYPE II FINISH, CLASS B

APRIL 4, 1927

REVISIONS

175-10-48

Y. P.

U.S.

EL 2

RED

BR.

FOOTNOTES

SCL

DRG. PERTAINS TO

5621076

30 BMG
M17A1(WC)
M19A4(FXD)
M19A4(FLEX)
M19A5(FXD)
M19A6

80

INSCRIBE ~~PART NO~~

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 5°

DRAFTSMAN E.L.U. CHIEF	TRACER Z.C. CHIEF	1ST DRAFTSMAN CHIEF DRAFTSMAN
-------------------------------------	--------------------------------	----------------------------------

SUBMITTED

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SECTION A-A

SECTION B-B

EJECTOR
STEEL FS 4140
FINISH 125 ✓

6017497

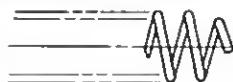
INSCRIBE MANUFACTURERS—
IDENTIFICATION $\frac{1}{16}$ HIGH

WAS B17497

SCALE $\frac{4}{1}$ B 6017497

HEAT TREATMENT AND FINAL FINISH

DRAW AT 450°F.
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F.



.109 ± .010

DIAMETER OF WIRE _____ .020
TOTAL NUMBER OF COILS _____ 9 1/2
OUTSIDE DIAMETER, FREE _____ .187 ± .004
MAX. OUTSIDE DIA AT MIN. OPERATING HEIGHT _____ .195
FREE LENGTH _____ .68 ± .02
TYPE OF ENDS _____ FORM AS SHOWN (BOTH ENDS)
WOUND _____ R. H.
MEAN ASSEMBLED HEIGHT _____ .362
MIN. LOAD AT MEAN ASSEMBLED HEIGHT _____ 1.58 LB
MIN. OPERATING HEIGHT _____ .321
MIN. LOAD AT MIN. OPERATING HEIGHT _____ 1.69 LB
LB PER INCH OF SPRING DEFLECTION _____ 4.9
SPRING FUNCTIONS IN HOLE _____ .200
CALCULATED MAX. SOLID HEIGHT _____ .180

CAUTION: DO NOT COMPRESS SOLID

NOTE:

.5% OF SPRINGS WILL BE FATIGUE TESTED
BETWEEN ASSEMBLED HEIGHT AND MINIMUM
OPERATING HEIGHT FOR 25,000 CYCLES. THE
LOAD AT ASSEMBLED HEIGHT, AFTER TESTING,
SHOULD NOT BE LESS THAN 1.25 LB

SPRING EXTRACTOR CAM PLUNGER**SPRING STEEL WIRE WDI085 SPECIAL - CLASS A**

6147228

PHYSICAL PROPERTIES

Y. P.

T. S.

EL. 2

RED

BR.

ROCK.

SCL.

FEBRUARY 1, 1938

REVISIONS

12 5-10-48

DRG. PERTAINS TO

C-5621076

50 T.M.G.
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

DO

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL: -

FRACTIONAL: -

ANGULAR: -

DRAFTSMAN

TACER

C. W. DRAFTSMAN

W. L. M.

M. C.

CHECKED

S. A.

CHIEF DRAFTSMAN

SUBMITTED:

A. H. Poe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Wickham

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS 8147228

B 6147228

B6147228

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

C44-52

OCTOBER 30, 1942

REVISIONS

4 5-10-48

DRG. PERTAINS TO

C5621076

30-MG
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: —

DESIGNER

J.B.M.

TECHNICAL

E.B.

C.O.S. SKETCHER

CHIEF DRAFTER

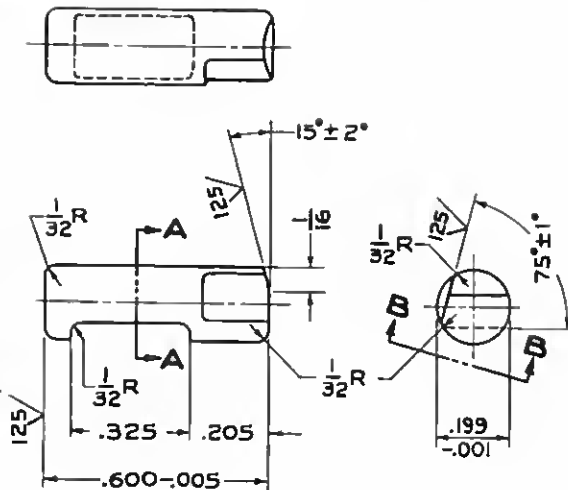
SUBMITTED:

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SECTION A-A



VIEW B-B

SCALE 10/1

PLUNGER, EXTRACTOR CAM

DRILL ROD

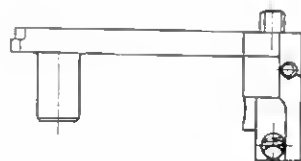
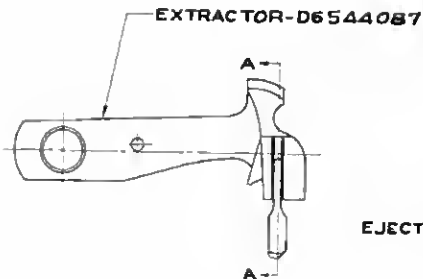
FINISH $\sqrt{63}$, OTHER SURFACES, AS SPECIFIED

6261101

WAS B261101

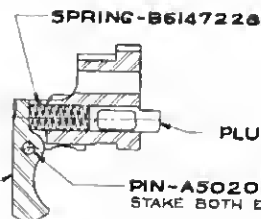
SCALE 4/1 B 6261101

B6261101

PIN-A5020570
STAKE BOTH ENDS

EXTRACTOR-D6544087

EJECTOR-B607497



SPRING-B6147228

PLUNGER-B62611DI

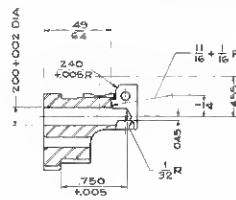
SECTION A-A

EXTRACTOR, ASSEMBLY 5621076

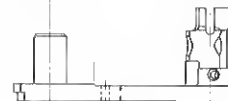
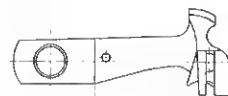
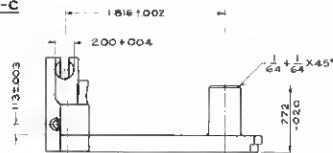
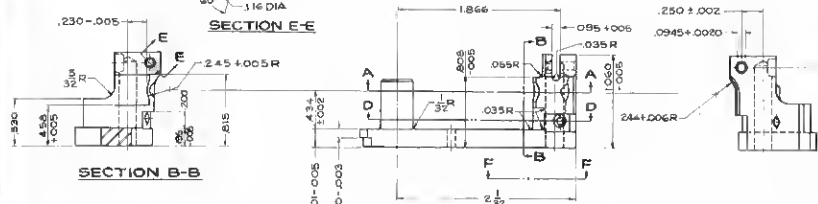
PHYSICAL PROPERTIES		OCTOBER 30, 1942	
		REVISIONS	
Y. P.	3	5-10-48	
T. S.			
EL. 4			
RED			
BR.			
ROCK			
SCL			
DRG. PERTAINS TO			
51-10-1	30 BNG		
	M17A (WC)		
51-23-1	30 BNG		
	M17A (FAC)		
51-24-1	30 BNG		
	M17A (FLEX)		
51-114-1	30 BNG		
	M17A (FAC)		
51-125-1	30 BNG		
	M17A (FAC)		

TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED	
DECIMAL: .0005	
FRACTIONAL: 1/16	
ANGULAR: .001	
DATE: 10/30/42	DESIGNED BY: E.R.G.
CHECKED BY: [Signature]	APPROVED BY: [Signature]
SUBMITTED	
WAS C121076	
DO NOT	UNSCREW PART NO.
5621076	
ORDNANCE DEPT., U. S. A.	

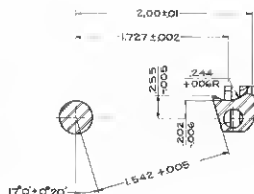
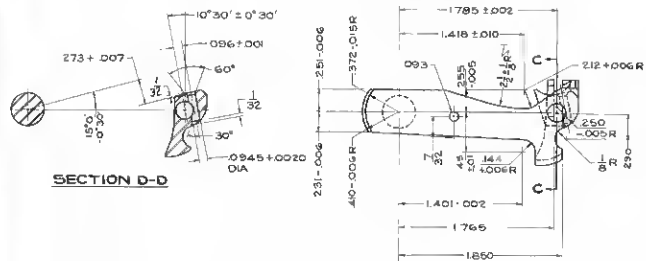




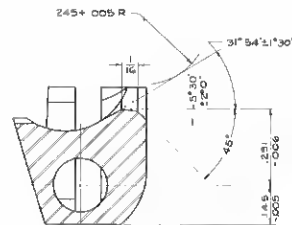
SECTION C-C



L195+.005 (TO AVOID MATCH-
ING CUTS)



SECTION A-A



PARTIAL SECTION A-A

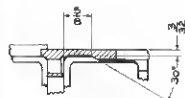
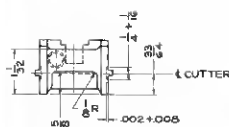
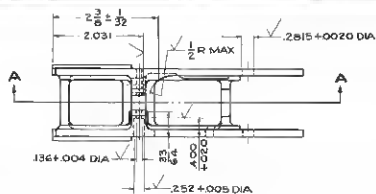
SCALE $\frac{6}{1}$

EXTRACTOR
STEEL FS 4140
FINISH 125
6644087

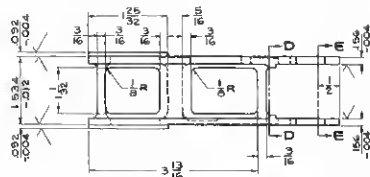
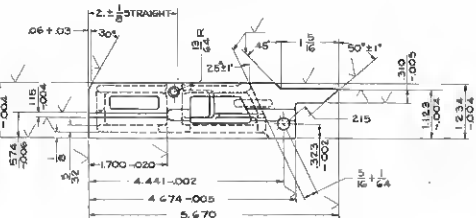
6544087

WAS D44087

SCALE $\frac{2}{3}$ [illegible]

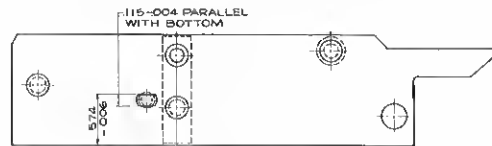
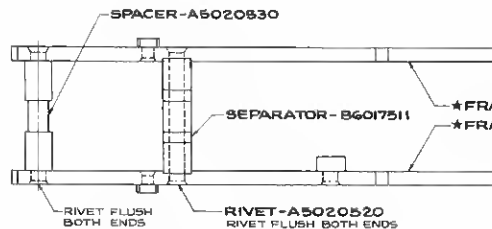
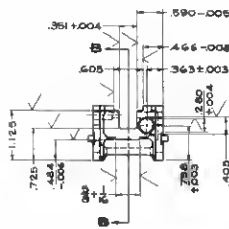


SECTION C-C

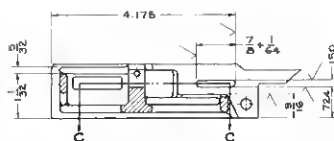


ALTERNATIVE CONSTRUCTION A
PEARLITIC MALLEABLE IRON - CLASS A

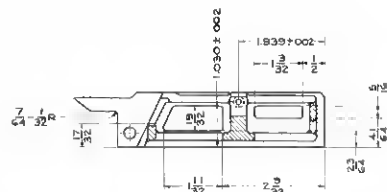
FINISH ✓ TO BE 12.5
SCALE $\frac{1}{4}$



FRAME, LOCK, ASSEMBLY (6509182)



SECTION A-A



SECTION B-5

NOTE:

SECTION D-D:

HEAT IN NEUTRAL SALT BATH AT 1500°F FOR 10 MINUTES, OIL QUENCH, DRAW AT 950°F FOR 30 MINUTES, AIR COOL.

SECTION E-E

HEAT IN CYANIDE AT 1500°-1550° F FOR 5 MINUTES, OIL QUENCH, DRAW AT APPROX 750° F IN SALT BATH FOR 30 MINUTES, AIR COOL, ROCK. C 47-52

ALL CAST RADII TO BE $\frac{1}{16}$ UNLESS OTHERWISE SPECIFIED.

★ FINDING DIAGRAM

INSCRIBE PART NO.

AUGUST 10, 1944		CLAIM	ISSUANCE	ISSUING	FILE
REVISIONS					
10 5-10-40					
TOLERANCE ON DIMENSIONS NOT SPECIFIED OTHERWISE VISCAL 3/4" DIA FRACTIONAL 3/16" DIA ANGULAR 3°					
MATERIAL		FINISH		TOL. SURFACES	
H.S.		Z.C.		1/2 DECIMAL	
COLOUR					
DRG. PERTAINS TO		SUBMITTALS			
51-10					
51-03					
51-24					
FLEX		EXAMINED			
SH. 14 1/2		NOT TO SCALE			
SH. 12 1/2		NOT TO SCALE			
D 5509182		ORDNANCE DEPT. U.S.A.			

A 5020530

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

APRIL 4, 1927

REVISIONS

11 5-10-48

DRG. PERTAINS TO

05509182

30 BMG
 M17A1 (WC)
 M19A4 (FXD)
 M19A4 (FLEX)
 M19AB (FXD)
 M19AG

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR \pm —

DRAFTSMAN

M.F.J.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKED



CHIEF DRAFTSMAN

SUBMITTED:



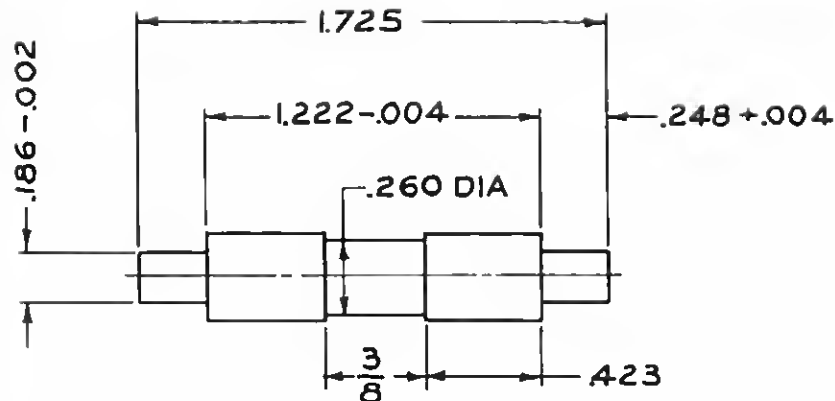
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE



ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**SPACER, LOCK FRAME****STEEL FSX1020**FINISH 125/


5020530

SCALE $\frac{2}{1}$

WAS A20530

A 5020530

A5020627

FEB. 1, 1927

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

16/5-10-48

DRG. PERTAINS TO

C5509180

30 BMG
 M 17A1 (WC)
 M 19A4 (FXD)
 M 19A4 (FLEX)
 M 19A5 (FXD)
 M 19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$
 FRACTIONAL $\pm 1/64$
 ANGULAR $\pm 5^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

CHECKER

L.R.E.

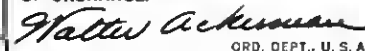
CHIEF DRAFTSMAN

SUBMITTED:



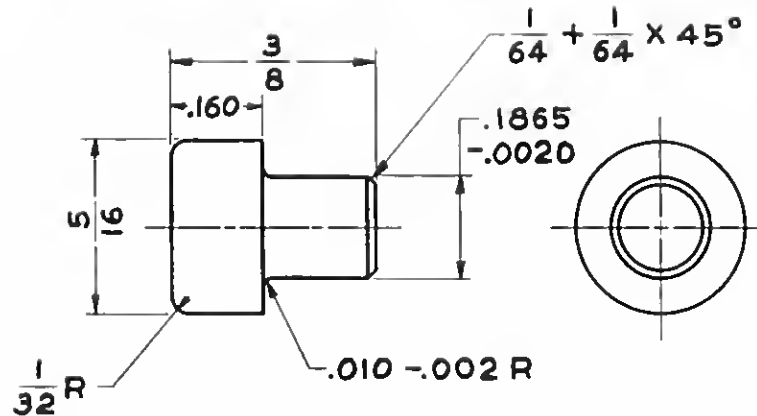
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE:



ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**STOP, ACCELERATOR**

DRILL ROD

FINISH 125/

5020627

WAS A20627

SCALE $\frac{4}{1}$

A 5020627

A 5135051

JUNE 1, 1931

REVISIONS

12 5-10-48

DRG. PERTAINS TO

C5509180

C5509181

30 BMG
M 17A1 (WC)
M 19A4 (FXD)
M 19A4 (FLEX)
M 19A5 (FXD)
M 19A6

INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 5^\circ$

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

L'D'S DRAFTSMAN

CHECKER

W.C.O.

CHIEF DRAFTSMAN

W.C.O.

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

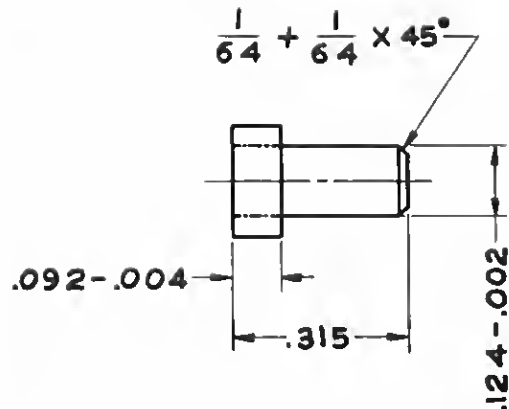
SCL

T. S.

BR.

EL 2

ROCK

MILL AT ASSEMBLY
C5509182GUIDE, LOCK FRAMEDRILL RODFINISH 125/

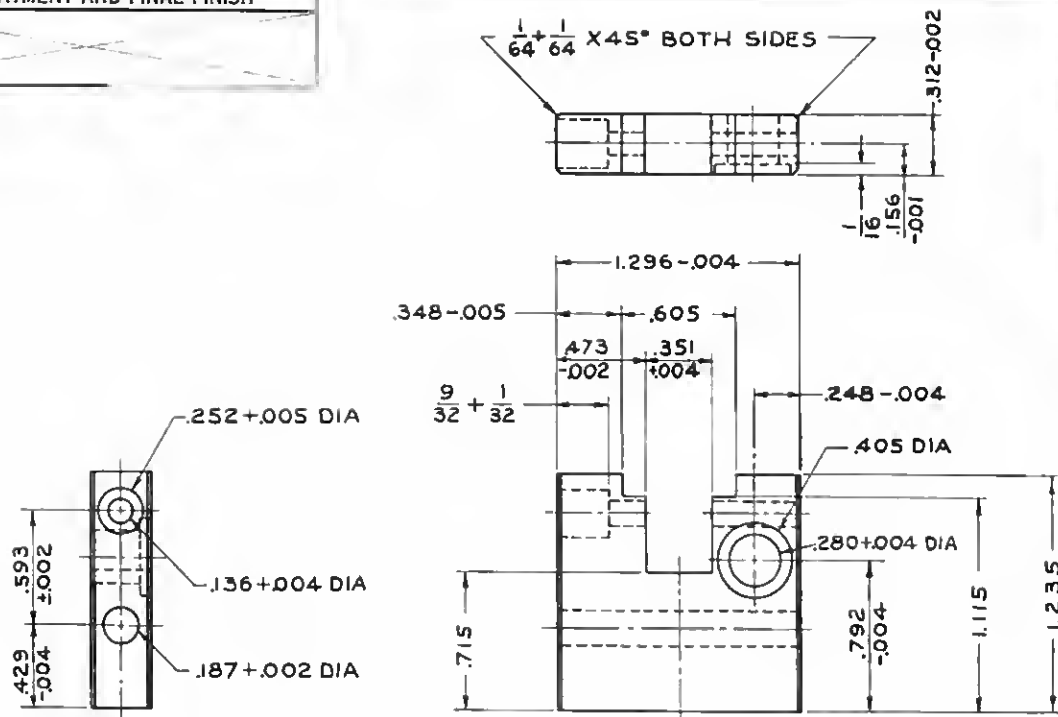
5135051

WAS A135051

SCALE $\frac{1}{1}$

A 5135051

HEAT TREATMENT AND FINAL FINISH



SEPARATOR, LOCK FRAME
 STEEL FSX1020
 FINISH $\frac{125}{\sqrt{}}$

6017511

SCALE $\frac{2}{1}$

B 6017511

WAS B17511

PHYSICAL PROPERTIES

Y. P.
 T. S.
 EL. 2
 RED
 BR.
 V. J.
 SCL.

APRIL 4, 1927

REVISIONS

165-10-48

DRG. PERTAINS TO

D5509182

M17A1 (WG)
 M19A4 (FXD)
 M19A4 (FLEX)
 M19A5 (FXD)
 M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: .005
 FRACTIONAL: $\frac{1}{64}$
 ANGULAR: 5°

DESIGNED	CHECKED	APPROVED	CHIEF DESIGNED
C.S.S.	AVC.	U.S. DEPT. OF ARMY	

SUBMITTED:

H. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:

H. Roe

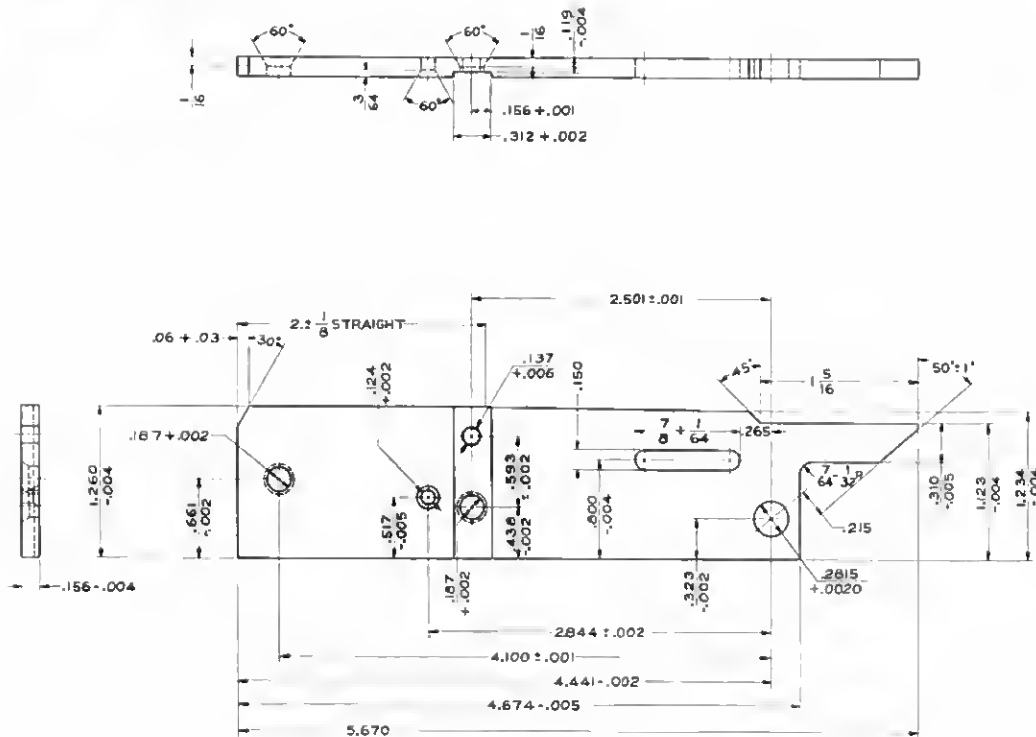
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

B6017511

HEAT TREATMENT AND FINAL FINISH

C.C. $\frac{1}{2}$ INCH ON CAM END .004
TO .008 DEEP (ROCK A74-78)



FRAME, LOCK, L.H.
LOW ALLOY STEEL, HIGH TENSILE - GRADE 2
FINISH 125

5508471

WAS C8471

DO NOT INSCRIBE PART NO.

SCALE $\frac{2}{1}$

5508471

PHYSICAL PROPERTIES		APRIL 4, 1927
		REVISIONS
Y P		1916-48
Y P		
EL 2		
RED		
BR		
ROCA		
SCL		

ORG. PERTAINS TO

5509161
M 7A1 (WC)
30 B MG
M 19A4 (FXD)
30 B MG
M 19A4 (FLX)
30 B MG
M 19A4 (FXD)
30 B MG
M 19A4

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL .008
FRACTIONAL
ANGULAR $\pm 5^\circ$

B.T.H. L.R.E.

SUBMITTED

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE

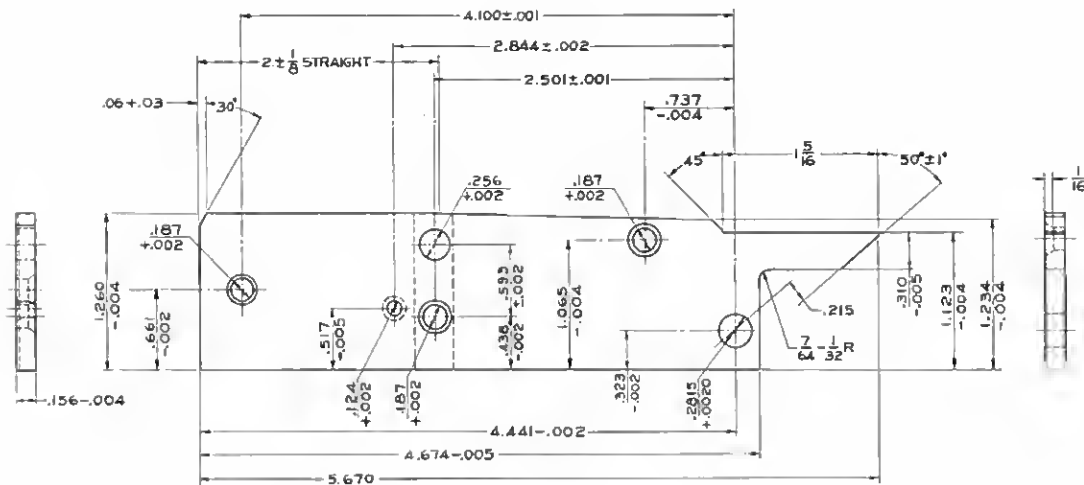
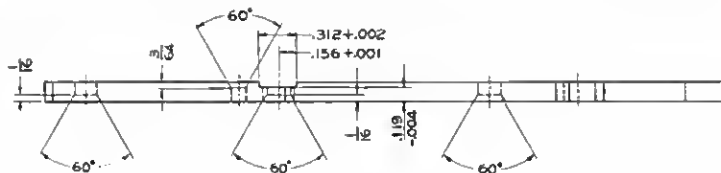
Walter A. Cushman

ORDNANCE DEPT., U. S. A.

MADE IN U.S.A.

C5508471

HEAT TREATMENT AND FINAL FINISH

C.C. $\frac{1}{2}$ INCH ON CAM END .004 TO .008 DEEP
(ROCK, A7A-7B)

FRAME, LOCK, R.H.
LOW ALLOY STEEL, HIGH TENSILE - GRADE 2
FINISH $\sqrt{125}$

5508472

PHYSICAL PROPERTIES	APRIL 4, 1927
REVISIONS	
V. P.	19 5-10-40
T. S.	
EL. 2	
RED	
BR	
ROCK	
SCL	

ORG. PERTAINS TO

5509180 30 BMS
M19A4 (W.C.)
30 BMS
M19A4 (FAC)
30 BMS
M19A4 (FLEX)
30 BMS
M19A4 (FAC)
30 BMS
M19A4

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMALS - .005
FRACTIONS - $\frac{1}{64}$
ANGULAR - 5'

B.T.M. E.B.
1/16" OF SHOOTING

SUBMITTED.

A.H. Roe

WAS C8472

DO NOT INSCRIBE PART NO.

SCALE $\frac{2}{1}$

5508472

APPROVED BY ORDER OF THE CHIEF
OF BUREAUWalter Anderson
CHIEF OF BUREAU
ORDNANCE DEPT., U. S. A.

MADE BY BUCK ISLAND ARSENAL

C5508472

HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
V P		11	5-10-40
T S			
EL S			
RED			
BN			
ROCK			
SCL			

ORG. PERTAINS TO

05509182	30 BMG
	M1A1(WC)
	30 BMG
	M1A4(PSD)
	30 BMG
	M1A4(FLEX)
	30 BMG
	M1A4(XD)
	30 BMG
	M1A6



FRAME-C5508472

STOP-A5020627



GUIDE-A5135051

FRAME, LOCK, R.H. ASSEMBLY

5509180

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL 2 —
FRACTIONAL 1 —
ANGULAR 1 —

DATE	TIME	BY
5/10/40	1:00	J. H. R. E.

SUBMITTED:

J. H. R. E.

WAS C9180

DO NOT DISCERN PART NO.

05509180

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter C. ...

ORDNANCE DEPT., U. S. A.

MADE AT BUCKINGHAM ARSENAL



C5509180

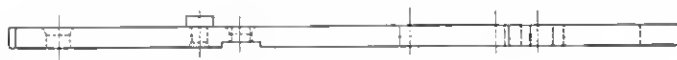
HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		11	5-10-48
Y. S.			
EL. 2			
RED			
BR			
ROCK			
SCL			

DRG. PERTAINS TO

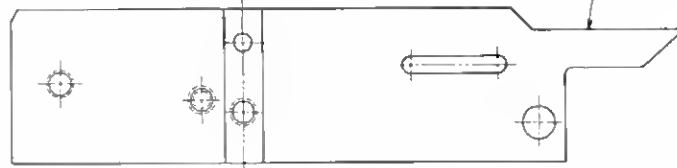
DRG. PERTAINS TO

05503182	30 BMG
	M17AI(WC)
	30 BMG
	M19AA(FXD)
	30 BMG
	M19AA(FLEX)
	30 BMG
	M19A5(FXD)
	30 BMG
	M19AG



FRAME-C5508471

GUIDE-A5135051



FRAME, LOCK, L.H., ASSEMBLY (550918)

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL 2 —
FRACTIONAL 2 —
ANGULAR 2 —

094170224	7201 07	1 0 0 000000000
M.E.B.	M.C.	

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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SUBMITTED: 1/16/2017

7/11/02

APPROVED FOR RELEASE OF THE UNITED STATES

OF ORDINANCE

Walter Lockman
UNITED STATES OF AMERICA

ORDNANCE DEPT., U. S. A.

WAS C9181

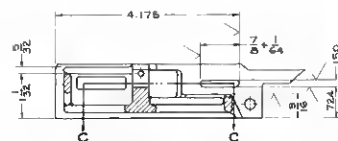
DO NOT INSCRIBE PART NO.

5509181

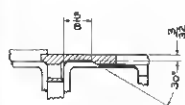
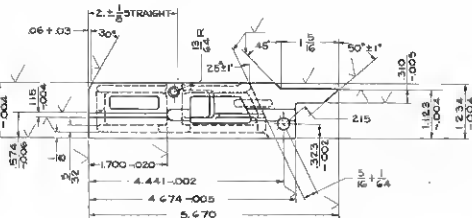
ORDNANCE DEPT., U. S. A.

© 2000 Blackwell Science Ltd *Journal of Internal Medicine* 247: 105–112

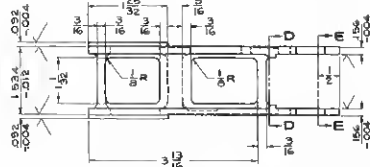




SECTION A-A

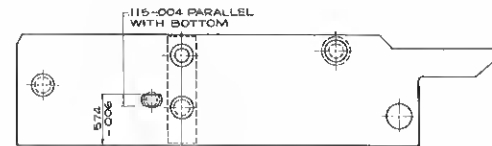
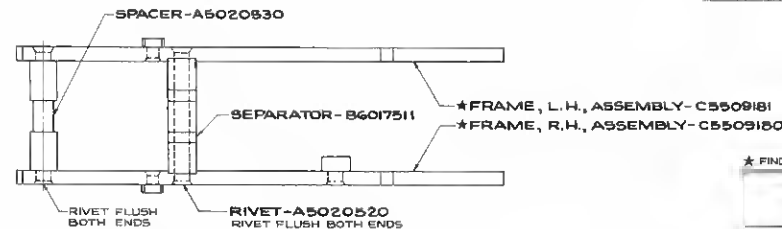
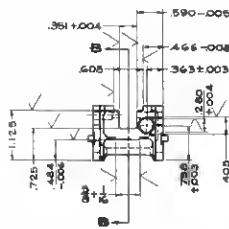


SECTION C-C

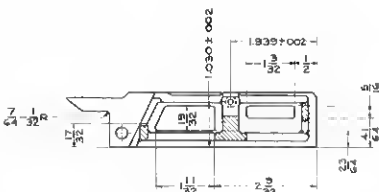


ALTERNATIVE CONSTRUCTION A
PEARLITIC MALLEABLE IRON - CLASS A

FINISH ✓ TO BE 12.5
SCALE $\frac{1}{4}$



FRAME, LOCK, ASSEMBLY (5509182)



SECTION B-B

ALL CAST RADII TO BE $\frac{1}{16}$ UNLESS OTHERWISE SPECIFIED.

★ FINDING DIAGRAM

DO NOT INSCRIBE PART NO.

AUGUST 17, 1954	CLAIM	REVISION	DRAWING	PAT.
REVISONS				
10 5-10-60				
	TO INCREASE ON DIMENSIONS NOT GENERALLY SPECIFIED DECIMAL 2 GOOD FRACTIONS 1/64 ANGULAR 2 R			
	ANALYSIS			TEST REPORT
	N.S.	Z.C.		
	CHECKED			CITY APPROVED
	SUBMITTED			
	A.H.R.			
	EXAMINED			
ORG. PERTAINS TO 51-110 100 BANG WINDING 51-83 100 BANG WINDING 51-84 100 BANG WINDING 51-84 100 BANG WINDING 51-14 100 BANG WINDING 51-125 100 BANG WINDING				
Hester Ackerman DES. SEC. 31.1				
D5509182				
CRANFORD DEPT. U.S.A. MADE OF PROTECTED DESIGN				

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL. 2

RED.

BR.

ROCK

SCL.

OCTOBER 7, 1943

REVISIONS

5 5-10-48

DRG. PERTAINS TO

51-10-1

.30 BMG
M17A1 (WC)

51-83-1

.30 BMG
M19A4 (FXD)

51-84-1

.30 BMG
M19A4 (FLEX)

51-114-1

.30 BMG
M19A5 (FXD)

51-125-1

.30 BMG
M19A6

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL \pm —
ANGULAR \pm —DRAFTSMAN
L.M.O.TRACER
J.H.

L'DG DRAFTSMAN

CHECKED
J.H.

CHIEF DRAFTSMAN

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:Walter C. Johnson
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

PLUNGER-A5238204

LATCH-C7106872

PIN-BFDX1, 505484 (STAKE BOTH ENDS)

SPRING-A7106092

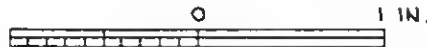
PLUG-A7106869

PLUNGER-A7106870

LATCH, ASSEMBLY

7106949

SUPERSEDES B7106949 WO/C 5-10-48



B 7106949

B7106949

A	5238204
---	---------

A 7106092

HEAT TREATMENT & FINAL FINISH

DRAW AT 450°F
 TYPE I FINISH, CLASS OSC
 BAKE ONE HOUR AT 300-350°F

MAX. O.D. AT MIN. OPERATING HEIGHT — .360
 MINIMUM OPERATING HEIGHT — 1.437
 LOAD AT MIN. OPERATING HEIGHT — 11.7 ± 1. LB
 LB. PER INCH OF SPRING DEFLECTION — 8.5
 SPRING FUNCTIONS IN HOLE — .378 ± .003
 OUTSIDE DIAM. SOLID, NOT MORE THAN — .345
 INSIDE DIAM. FREE, NOT LESS THAN —
 ASSEMBLED HEIGHT — 1.640
 LOAD AT ASSEMBLED HEIGHT — 10. ± 1. LB
 SOLID HEIGHT, NOT MORE THAN — 1.215
 DIAM. OF WIRE (APPROX.) — .045
 FREE HEIGHT (APPROX.) — 2.8125
 NUMBER OF COILS (APPROX.) — 27
 DIRECTION OF COILING — R.H. OR L.H.
 ENDS CLOSED AND GROUND FLAT. — SQ & GR.

CAUTION: DO NOT COMPRESS SOLID

SPRING, LATCH

SPRING STEEL WIRE WD1085 SPECIAL-CLASS A

(7106092

SUPERSEDES A7106092 WO/C 5-10-48

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL-2

RED.

HT. T.

BR.

SCL.

C. C.

MARCH 9, 1944

REVISIONS

3 5-10-48

DRG. PERTAINS TO

B7106949

30 8M6
 M17A1 (WC)
 M19A4 (FXD)
 M19A4 (FLEX)
 M19A5 (FXD)
 M19A6

SYMBOL

DRAFTSMAN

W.B.H.

TRACER

M.C.

ENGINEER

CHECKER

W.B.H.

O.O.

ENGINEER

SUBMITTED:-

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED:-

Walter Ackerman

ORD. DEPT., U. S. A.

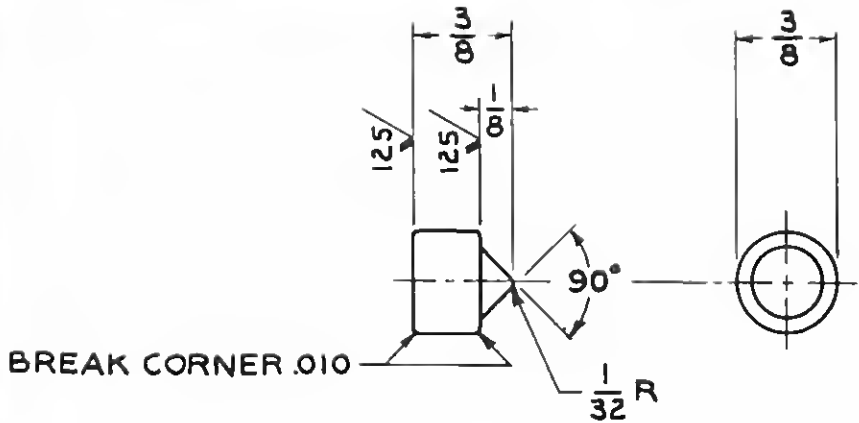
ORDNANCE DEPT., U. S. A.

A 7106092

A7106869

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				OCTOBER 7, 1943	
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.		RED.		SCL.	
		T. S.		BR.		C.C.	.005-.010 DRG
		EL. 2		ROCK			

REVISIONS			
4	5-10-48		



DRG. PERTAINS TO	
B7106949	MITAI(WC) M19A4(FXD) M19A4(FLEX) M19A5(FXD) M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 1^\circ$

DRAFTSMAN H.W.J.	TRACER A.V.C.	L'D'G DRAFTSMAN
CHECKER H.W.J.		CHIEF DRAFTSMAN

PLUG, RETAINING
STEEL FS1020
FINISH 63/, OTHER SURFACES, AS SPECIFIED

7106869

SUBMITTED:
A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Ackerman
ORD. DEPT. U. S. A.
ORDNANCE DEPT., U. S. A.









SUPERSEDES A7106869 WO/C 5-10-48 SCALE $\frac{2}{1}$ **A 7106869**

A 7106870

HEAT TREATMENT & FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES

Y. P.		RED.		SCL.	
T. S.		BR.		C. C.	.005-.010 
E. L. 2		ROCK			

OCTOBER 7, 1943

REVISIONS

4 5-10-48


DRG. PERTAINS TO

B7106949

.20 BMG
M 17A1 (WC)
M 19A4 (FXD)
M 19A4 (FLEX)
M 19A5 (FXD)
M 19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 1^\circ$

DRAFTSMAN H.W.J.	TRACER A.V.C.	L'D'G DRAFTSMAN
CHECKER H.W.J.		CHIEF DRAFTSMAN

SUBMITTED:

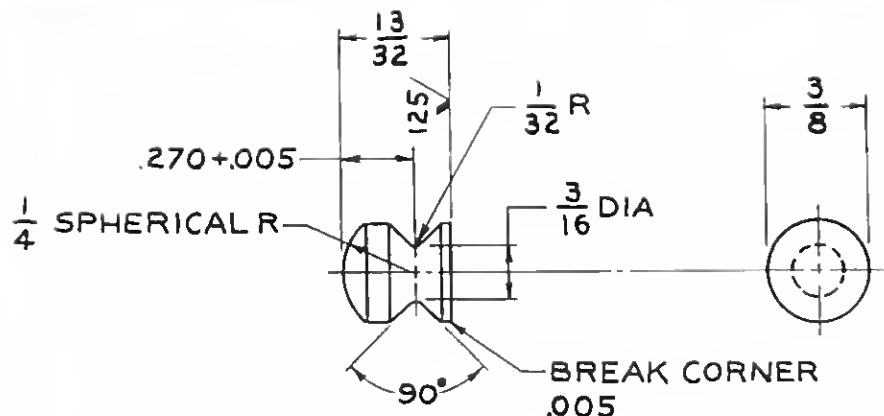


APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE



ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**PLUNGER, FRICTION****STEEL FS 1020**

7106870

FINISH $\frac{63}{\sqrt{}}$, OTHER SURFACES AS SPECIFIED

SUPERSEDES A7106870 WO/C 5-10-48 SCALE $\frac{2}{1}$ **A** **7106870**

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL. 2

RED.

BR.

ROCK

SCL.

OCTOBER 7, 1943

REVISIONS

5 5-10-48

DRG. PERTAINS TO

51-10-1

.30 BMG
M17A1 (WC)

51-83-1

.30 BMG
M19A4 (FXD)

51-84-1

.30 BMG
M19A4 (FLEX)

51-114-1

.30 BMG
M19A5 (FXD)

51-125-1

.30 BMG
M19A6

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL \pm —
FRACTIONAL \pm —
ANGULAR \pm —

DRAFTSMAN

L.M.O.

CHECKED

3-10-48

SUBMITTED:

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

ORDNANCE DEPT., U. S. A.

PLUNGER-A5238204

LATCH-C7106872

PIN-BFDX1, 505484 (STAKE BOTH ENDS)

SPRING-A7106092

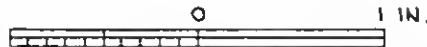
PLUG-A7106869

PLUNGER-A7106870

LATCH, ASSEMBLY

7106949

SUPERSEDES B7106949 WO/C 5-10-48



B 7106949

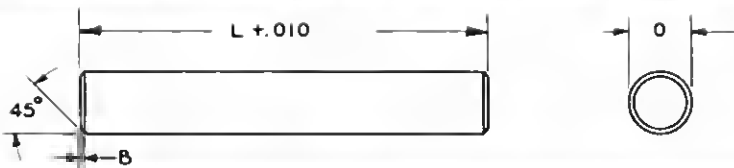
B7106949

PIN, STRAIGHT, STEEL CHAMFERED

BFDXI

ORDNANCE DEPT STANDARDS (ORDNANCE DESIGN)

W.H.G. 1-31-34
APPROVED DATE



D OF PIN B	DIAMETER OF PIN CHAMFER	{ NOM. MAX. MIN.	1/16	3/32	1/8	5/32	3/16
			.0630 .0620 .010	.0942 .0932 .010	.1255 .1245 .010	.1567 .1557 1/64	.1880 .1870 1/64

L LENGTH	ORDNANCE PART NUMBER - PLAIN FINISH					
1/8	505461	544188				
3/16	505462	544072	544019			
1/4	505463	505470				
5/16	505464	505471	544029			
3/8	505465	505472	505481			
7/16	505466	505473	505482	544020	544055	
1/2	505467	505474	505483	505494		
9/16	505468	505475	505484	505495	544028	
5/8	505469	505476	505485	505496	505506	
11/16		505477	505486	505497	505508	
3/4		505478	505487	505498	505509	
13/16	544070	505479	505488	505499	505510	
7/8		505480	505489	505500	505511	
15/16			505491	505501	505512	
1			505492	505502	505513	
1-1/8			505493	505503	505514	
1-1/4				505504	505515	
1-3/8				505505	505516	
1-1/2	426778				505517	
1-5/8		544075			505518	
1-3/4					505519	

L LENGTH	ORDNANCE PART NUMBER - PHOSPHATE (OILED) FINISH					
5/8					505507	
7/8			505490		582953	
1-1/8			544179			
1-3/8					582954	

MATERIAL:

DRILL ROD, COMMERCIAL. TOLERANCE ON DRILL ROD $\pm .0005$ ". DIMENSIONS IN INCHES.
NOMENCLATURE PATTERN: PIN, STRAIGHT, DRILL ROD, 1/8" x 1/2", PLAIN, DRG. BFDXI,
PART NUMBER 505483.

NOTE: PINS SHOULD BE .0005" TO .001" DRIVE FIT.

HEAT TREAT (SEE NOTE)
TYPE II FINISH, CLASS B

--	--

A78-A82

SCALE

LATCH
PEARLITIC MALLEABLE IRON-CLASS A
FINISH ✓ TO BE 125/

7106872

NOTE: B.I.A. FORGING FOR ALTERNATIVE MATERIAL SHOWN ON C7101711

ORDNANCE DEPT., U. S. A.

DO NOT INSCRIBE PART NO

SCALE $\frac{2}{1}$

C 7106872

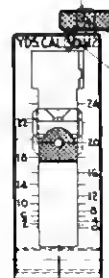
SUPERSEDES C710687Z WO/C 5-10-48

ORG. PERTAINS TO

65564906	50 EMB
	M19AA (FAD)
	M19AA (FLEX)
	M19AG



INSCRIBE PART NUMBER
1/16" HIGH -



— .0500+.0005

→ RIVET OR STAKE
PIN ON BOTH ENDS

LEAF, REAR SIGHT, ASSEMBLY

5545964

DO
INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DIGITAL -
FRACTIONAL -
ANGULAR -

DATE OF ISSUE: _____ PRICE: _____ U.S. GOVERNMENT PRINTING OFFICE: 1963 O - 350-000

H.M.F. *Lee*

Lee 1.000 INCHES

SUBMITTED:

A.H. Roe

APPROVED BY CHIEF OF THE DIVISION OF ORIGIN:

Walter Ackerman

DATE: _____

DEFENSE DEPT., U. S. A.

WAS R45364

5545964



A13166

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MAY 1, 1929.

Y.P.

RED.

ROCK.

PRECISIONS

T.S.

BR.

162 6-16-44

172 4-30-46

183 CONVERSION 7-28-49

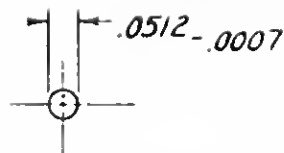
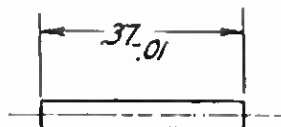
197 3-24-49

PROTECTIVE FINISH TYPE II CLASS A Q.H. 15

DO NOT INSCRIBE PART NO.

DR'G. PERTAINS TO

51-13	30 BAR-M18
51-180	30 BAR-M1918A2
C5564208	LEAF, REAR SIGHT, ASM.
51-77	30 BMG-M19A2
C5564061	LEAF, REAR SIGHT, ASM.
51-89	30 BMG-M19A4 (FXD.)
51-84	30 BMG-M19A4 (FLEX.)
51-125	30 BMG-M19A6
C55640564	LEAF, REAR SIGHT, ASM.
51-74	30 BMG-M19A6 (FXD.)
51-75	30 BMG-M19A6 (FLEX.)
C5564057	LEAF, REAR SIGHT, ASM.
51-70	50 BMG-M2HB (FLEX.)
51-71	50 BMG-M2HB (FXD.)
51-88	50 BMG-M2HB (FXD.)
C5564061	LEAF, REAR SIGHT, ASM.



5013166

PIN, REAR SIGHT ELEVATING KNOB
STEEL W.D. 1095
 FINISH f

(A13166-17)

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED
 SUPERSEDES OLD TRACING A13166
 UNDER REVISION DATE OF JUNE 16, 1944.

SCALE $\frac{4}{1}$

SPRINGFIELD ARMORY

A5013166

A13166

DFTSMAN <i>[Signature]</i>	TRACER <i>[Signature]</i>	LDG DFTSMAN <i>[Signature]</i>
CHECKER <i>[Signature]</i>	<i>[Signature]</i>	CHIEF DFTSMAN <i>[Signature]</i>

SUBMITTED:

[Signature]
 HD. ORD. ENG. ORD. DEPT.
 APPROVED BY ORDER OF THE
 CHIEF OF ORDNANCE:
[Signature]
 LT COL. ORD. DEPT.
 ORDNANCE DEPT., U. S. A.

SUPERSEDES A13166

A5013166

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A5152432

MARCH 10, 1939

REVISIONS

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

C. C.

.010 TO .012
DEEP

EL. 2

ROCK

8 5-10-48

DRG. PERTAINS TO

C5545964

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 5^\circ$

DRAFTSMAN

H.D.C.

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKER

L.S.C.

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

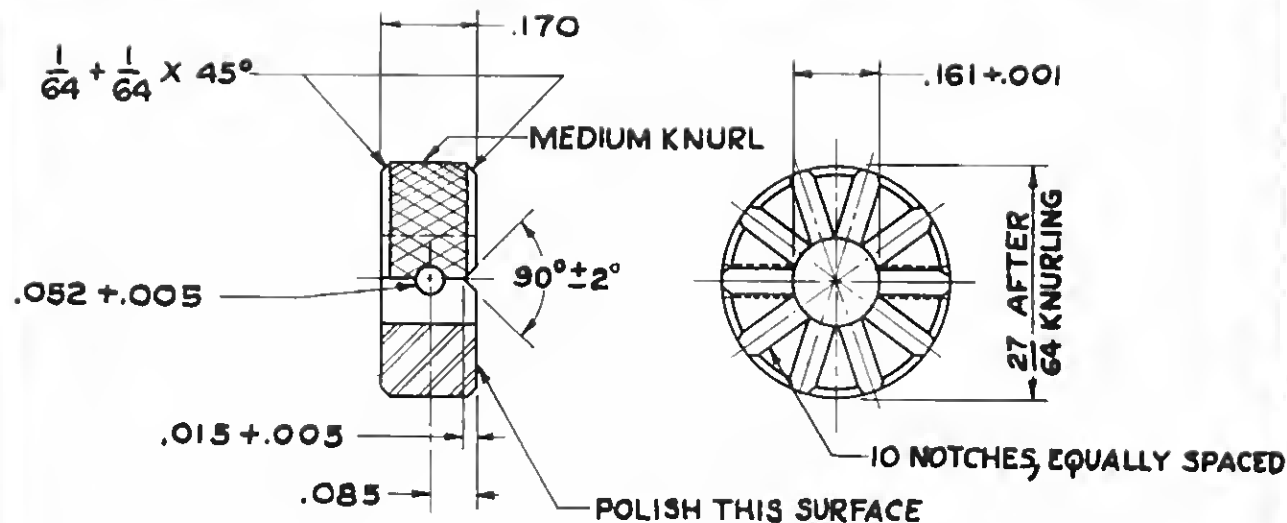
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

KNOB, REAR SIGHT ELEVATING SCREW (5152432)STEEL FSX1020FINISH 125/
V

WAS A152432

SCALE $\frac{4}{1}$

A 5152432

HEAT TREATMENT & FINAL FINISH

DRAW AT 450 F.

PROTECTIVE FINISH TYPE I CLASS D,S,C.

~~DO NOT~~ INSCRIBE PART NO.

MARCH 19, 1939

REVISIONS

7	8-15-42		
8	10-24-42		
9	7-27-43		
10	2-7-44		
11	4-30-46		
12	CONVERSION 1-28-49		

DRG. PERTAINSTO

C45964	LEAF, REAR SIGHT, ASSEMBLY
C64200	LEAF, REAR SIGHT, ASSEMBLY
C5364208	ASSEMBLY
51-83	.30 BMG-M19A4 FXD.
51-84	.30 BMG-M19A4 FLEX.
51-102	.30 BAR-M18A2
51-113	.30 BAR-M18
51-125	.30 BMG-M19A6

Δ	DIAMETER OF WIRE0135
☆	TOTAL NUMBER OF COILS	5
Δ	MINIMUM INSIDE DIAMETER, FREE040
Δ	OUTSIDE DIAMETER, FREE071 ± .003
Δ	MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT075
☆	FREE LENGTH OF SPRING138
Δ	TYPE OF ENDS	PLAIN
☆	WOUND	R.H.
☆	MEAN ASSEMBLED HEIGHT106
Δ	LOAD AT MEAN ASSEMBLED HEIGHT	2 LBS ± 1/2 LB.
☆	MINIMUM OPERATING HEIGHT093
Δ	LOAD AT MINIMUM OPERATING HEIGHT	2.68 LBS. ± 1/2 LB.
☆	LBS. PER INCH OF SPRING DEFLECTION	62 LBS.
Δ	SPRING FUNCTIONS IN HOLE076
☆	SPRING FUNCTIONS OVER ROD038
☆	MAXIMUM SOLID HEIGHT084

Δ NOTE:-THIS SPRING SHALL WITHSTAND OPERATIONS
BETWEEN ASSEMBLED HEIGHT AND MINIMUM OPERATING
HEIGHT WITHOUT FAILURE AND THE LOAD AT AS-
SEMBLED HEIGHT SHALL NOT BE LESS THAN LBS.
AFTER 25,000 OPERATIONS. SPEED OF TEST SHALL
NOT BE LESS THAN 500 CYCLES PER MINUTE.

Δ END COILS SHALL BE WITHIN MIN.
INSIDE DIA. AND FREE FROM BURRS.

SPRING, CLICK, PLUNGER ~~A163397-11~~
SPRING STEEL WIRE - WD 1085 SPECIAL CLASS A

5163397

SYMBOLS:- Δ MANDATORY REQUIREMENTS
☆ MANUFACTURING DATA

SUPERSEDES OLD TRACING A163397
UNDER REVISION DATE OF AUGUST 15, 1942.

A5163397

A163397

Dr. Tamm	TRACED	LD. C. P. 13
	R.S.	E. C. P.
CHECKED	FILED	GROUP 13
M.C. 20	11-20	20

SUBMITTED

E. C. P.
PROD ENG ORD DEPT.
APPROVED BY ORDER OF
THE CHIEF OF ORDNANCE
W. C. Smith
COL ORD. DEPT.

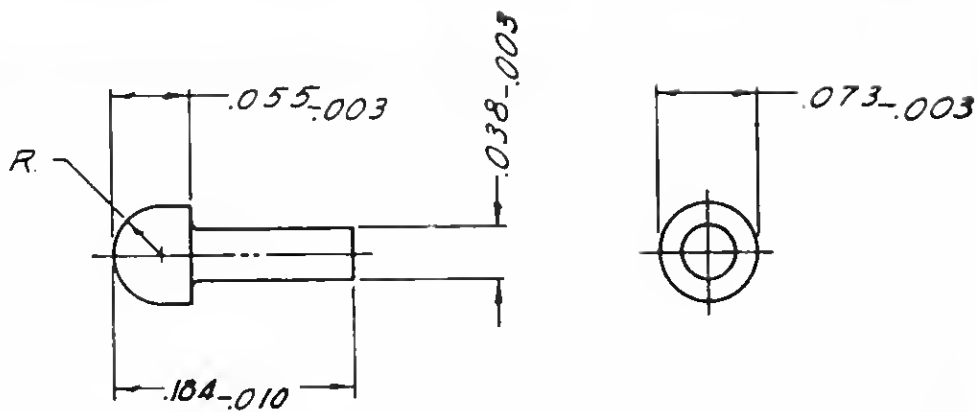
ORDNANCE DEPT USA

SUPERSEDES A163397

A5163397

A163398

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES					MARCH 10, 1939			
HEAT TREAT OXIDE BLACK	Y.P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.		REVISIONS			
	T.S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>	C.C.	.001% .003 DEEP	1*	2-7-40	5' 6-28-41	
	EL. 2	<input checked="" type="checkbox"/>	ROCK.	<input checked="" type="checkbox"/>			2'	6-25-40	6' 4-11-42	



PLUNGER, CLICK, REAR SIGHT ELEVATING SCREW KNOB
STEEL - W D 1020 COLD DRAWN
FINISH f

5163398
 (A163398-3)

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED SCALE 10/7

DR'G. PERTAINS TO	
51-83	30BMG-M19A4(FXD)
51-84	30BMG-M19A4(FLEX)
51-102	30 BAR-M18A2
C45964	LEAF, REAR SIGHT, ASM.
664208	LEAF, REAR SIGHT, ASM.
51-13	30 BAR M18
51-125	30 BMG-M19A6
C5564208	

SYMBOL		
DO NOT INSCRIBE PART NO.		
DFTSMAN M. J.	TRACER M. J.	L'VE. FTSMAN G. J. O.
CHECKER L. L. B.	CHIEF FTSMAN J. H. S.	
SUBMITTED: J. H. S. / Weller Sinton		
MAJ. ORD. DEPT. U. S. A.		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:		
S. H. S. LT. COL. ORD. DEPT. U. S. A.		
ORDNANCE DEPT. U. S. A.		

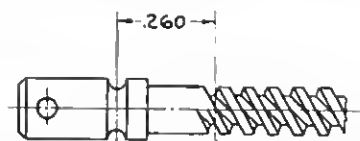
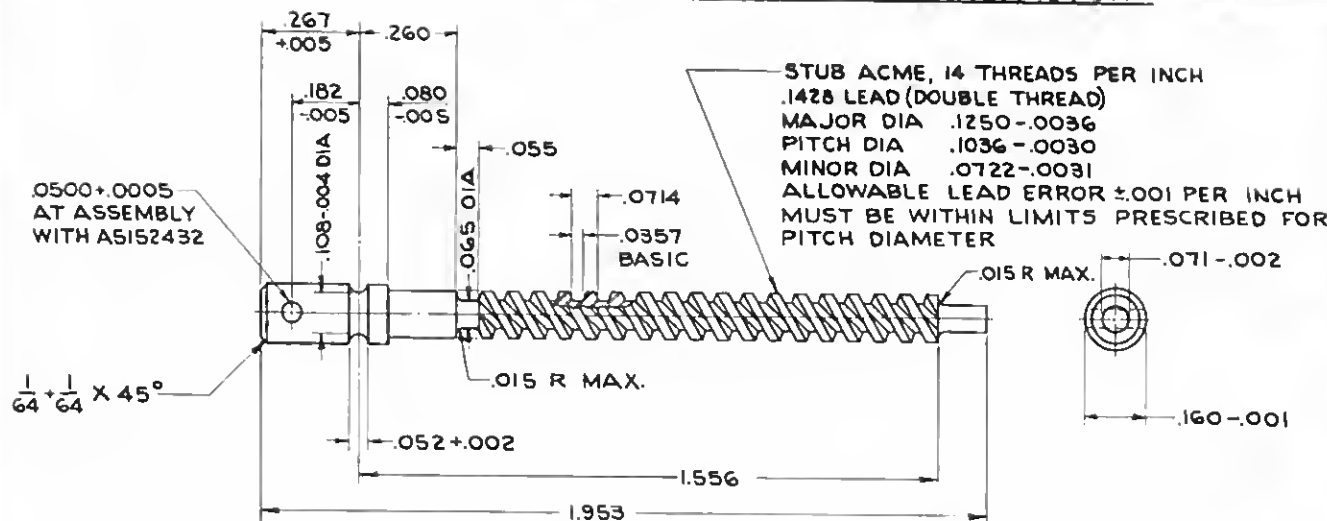
A5163398
 A163398

SUPERSEDES A163398

A 5163398

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

FULL THREAD DEPTH
TO THIS POINTALTERNATE METHOD OF MANUFACTURESCREW, ELEVATING, REAR SIGHT

STEEL FSX1315

FINISH $\frac{63}{\sqrt{}}$

G110312

SCALE $\frac{4}{1}$ PHYSICAL
PROPERTIES
 Y. P.
 T. S.
 EL. 2
 RED
 BR.
 ROCK.
 SCL.

MARCH 10, 1939

REVISIONS

8	5-10-48		

DRG. PERTAINS TO

C5545864 30 BMS-M1946
(FXD) & (FLX)

DO NOT INSCRIBE PART NO.

 TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: .008
 FRACTIONAL: $\frac{1}{64}$
 ANGULAR: 5°

DESIGNER C.P.L.	CHECKER S. J. [Signature]	U.S. INSPECTOR [Signature]
CHIEF DESIGNER [Signature]	CHIEF INSPECTOR [Signature]	

SUBMITTED:

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:Walter Ackerman
ORD. DEPT., U. S. A.

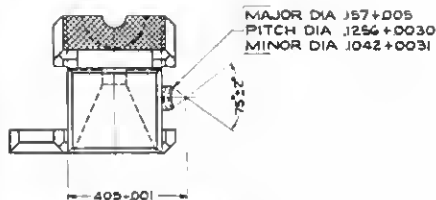
ORDNANCE DEPT., U. S. A.

WAS B110312

B G110312

B6110312

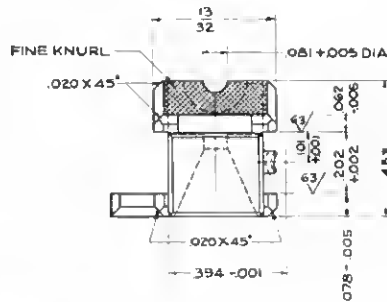
ORG. PERTAINS TO

[illegible][illegible]

ALTERNATIVE MANUFACTURE
OF STUB ACME THREAD
SAME AS STANDARD THREAD
EXCEPT AS NOTED

NOTE .

INDEX LINES TO BE FILLED
WITH WHITE ENAMEL



SLIDE, REAR SIGHT
STEEL FSX1020

FINISH $\frac{125}{V}$, OTHER SURFACES, AS SPECIFIED

5545961



SECTION A-A

MAJOR DIA .135+0.05
PITCH DIA .1036+.0030
MINOR DIA .0822+.0031
ALLOWABLE LEAD ERROR ± 0.001
PER INCH AND INCLUDES
INDEXING ERROR, ALL OF
WHICH MUST BE WITHIN
LIMITS PRESCRIBED FOR
PITCH DIAMETER

STUB ACME (DOUBLE THREAD)
14 THREADS PER INCH
LEAD = .1428
FINISH $\frac{63}{\sqrt{}}$

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL : .005
FRACTIONAL : 1/64
ANGULAR : 15°

CPL. Z.C.

SUBMITTED

APPROVED BY OFFICE OF THE CLERK

CP Command
2000 10/10/00

姓名: 王明 性别: 男 年龄: 25 职业: 教师
 单位: XX中学 电话: 12345678 邮编: 100000
 地址: XX路XX号 电子邮箱: 12345678@163.com

ORDNANCE DEPT., U. S. A.

WAS C45961

INScribe PART NO.

SCALE $\frac{1}{2}$

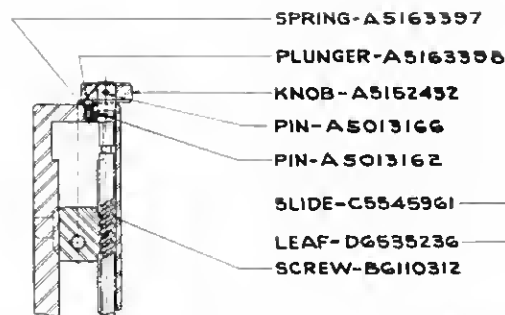
554596

PHYSICAL PROPERTIES		MARCH 10, 1939	
		REVISIONS	
Y. P.		4	5-10-40
T. S.		5	0-21-40
EL. 2		6	11-15-40
REC.			
BR.			
ROCK.			
SCL.			

ORG. PERTAINS TO

055645964

10 BMB
M1944 (FAD)
M1944 (FLEX)
M1946

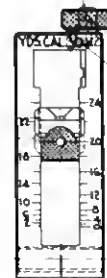


SECTION A-A

HOLE DRILLED IN SCREW FROM KNOB WHEN INDEX LINE ON SLIDE IS ALIGNED WITH MIL GRADUATION 48 AND CLICK IS ENGAGED IN GROOVE OF KNOB



INSCRIBE PART NUMBER
1/16" HIGH



.0500 ± .0005

RVET OR STAKE
PIN ON BOTH ENDS

LEAF, REAR SIGHT, ASSEMBLY

5545964



WAS C45964

05545964

DO
INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± .005
FRACTIONAL ± .005
ANGULAR ± .005

DESIGNED BY H.M.F. *SL*
CHECKED BY *SL*
DATE 10-1-40

SUBMITTED

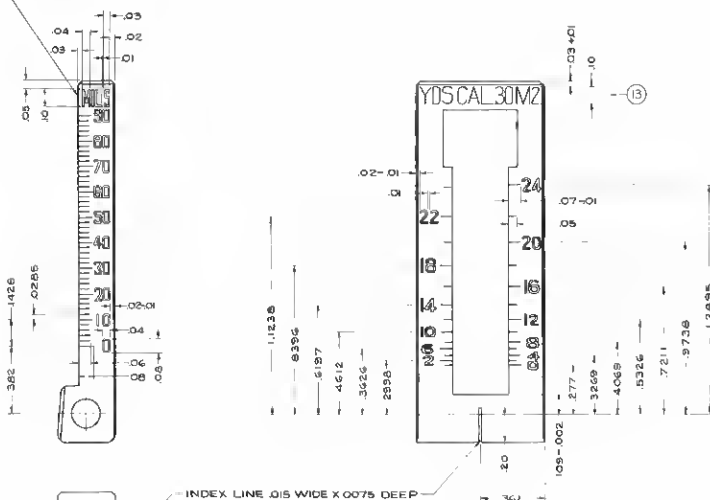
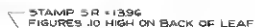
H.M.F.

APPROVED BY *Walter Anderson*
OF ORIGIN
DATE 10-1-40

ORIGIN DEPT. U. S. A.

MADE AT WASH. REAR SIGHT ASSEMBLY

5545964

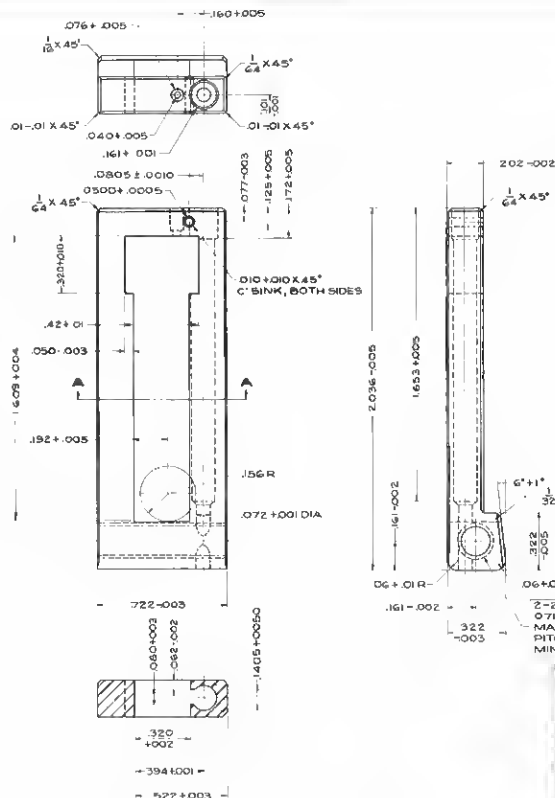


NOTE -
GRADUATIONS .01 WIDE X .005 DEEP
GRADUATIONS AND FIGURES TO BE
FILLED WITH WHITE ENAMEL
TOLERANCES ON LOCATION OF GRADUATIONS $\pm .003$

NOTE: SIZE OF FIGURES ON FACE OF LEAF
1 TO 8 INCLUSIVE .045 X .06 WIDE
10 TO 12 INCLUSIVE .06 X .06 WIDE
14 TO 18 INCLUSIVE .08 X .06 WIDE
20 TO 24 INCLUSIVE .08 X .05 WIDE

DATA USED IN CALCULATIONS	
SIGHT RADIUS -----	13.957
4 OF BORE TO TIP OF FRONT SIGHT -----	3.446
4 OF BORE TO AXIS OF LEAF JOINT PIN -----	3.169
CONSTANT (SIGHT ABOVE JOINT PIN AXIS) -----	.277
GRADUATIONS COMPUTED FROM FIRE CONTROL TABLE	030-C-3
PREPARED BY ORDNANCE DEPT DATED APRIL 1934	
CALCULATIONS FOR GRADUATIONS BASED ON -----	14.285 R

LEAF, REAR SIGHT (6535236)
STEEL FSx1020
FINISH 125



SECTION A-A

2-28NS-3
0714 LEAD, DOUBLE THREAD
- MAJOR DIA 2000 MIN
PITCH DIA .1768 +.0030
MINOR DIA .1613 +.0039

DO NOT INSTITUTE, PART NO

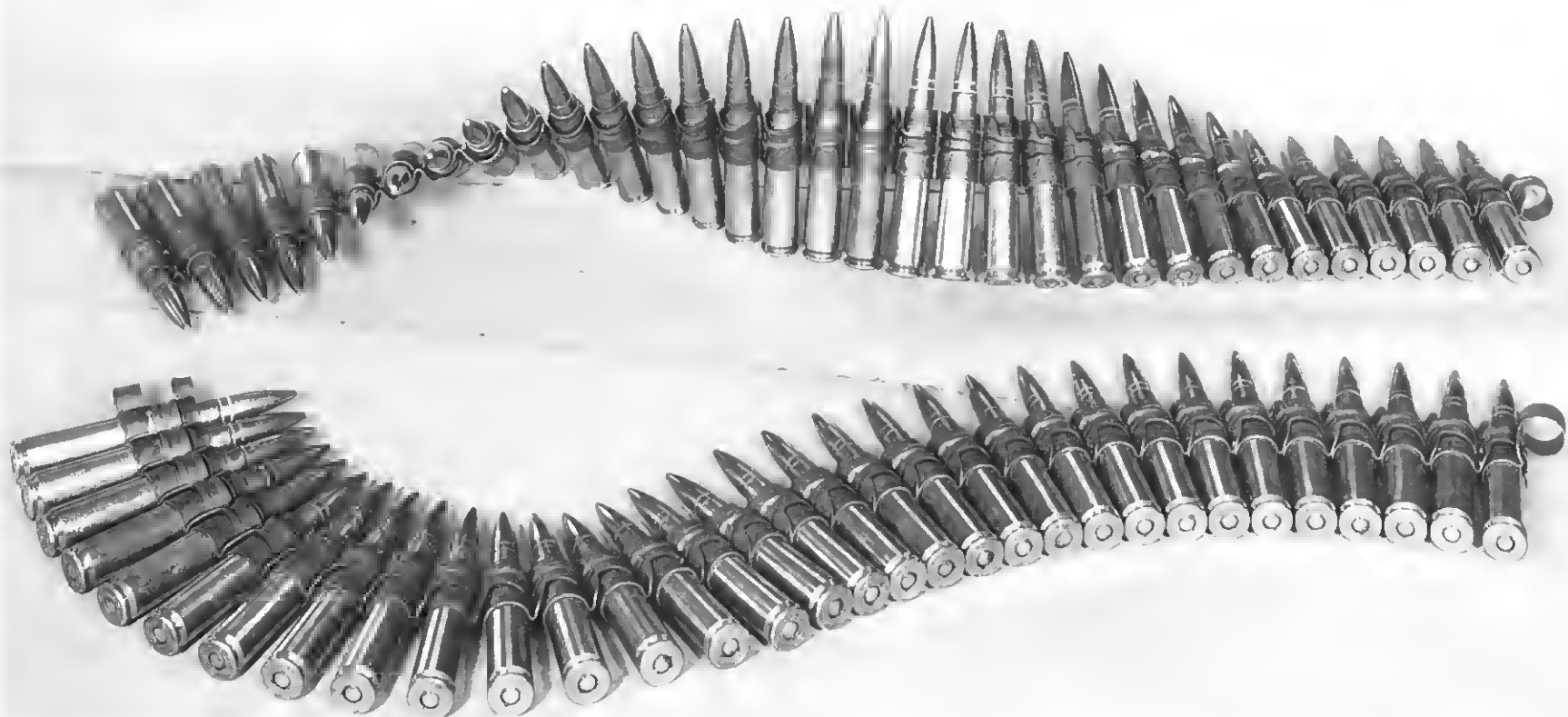
MARCH 10, 1959		CLAR	DETROIT	349400	7.15
REVISONS					
12	15-0-40				
13	10-2-40				
		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMALS OR FRACTIONS - 1/64 ANGULAR ± .5°			
		FINISHES	ZC - 115 IMPREG		
		C PL	ZC		
		LATE DELIVERY			
DRG. PERTAINS TO					
5545964	NOTING IN 1944 FROM MURRAY (LUC)				
<p>APPROVED BY: CHIEF OF THE CITY OF OMAHA</p> <p><i>Walter A. ...</i></p>					
D 6535236		ORDNANCE DEPT., U.S.A.			
NOT RECORDED					

WAS 035236

SCALE

D 6535236

ORD. DEPT., U.S.A.
 ADDRESS OF THE CHIEF OF DEPARTMENT
Walter A. Anderson
 ORD. DEPT., U.S.A.
 ORD. DEPT., U.S.A.
 NAME OF THE CHIEF OF DEPARTMENT



701-43073

ROCK ISLAND ARSENAL ORDNANCE DEPARTMENT

September 29, 1952

Link, Metallic Belt, Cal..50, M9. Flexibility of Assembled Belt.



701-43174

ROCK ISLAND ARSENAL ORDNANCE DEPARTMENT

October 15, 1952

Links, Metallic Belt, Cal..50, M9, Dwg. D7140393 and Cal..30, M1, Dwg. D5559722.

LINE NO.	LIST OF DRAWINGS	DRAWING NUMBER	REVISION
			SYM DATE
1	LINK, METALLIC BELT, CAL. .30, M, AND LIST OF DRAWINGS AND SPECIFICATIONS	D5559722	
2	CASE, CARTRIDGE, CAL. 30, MI	B6000045	
4	CARTON, METALLIC BELT LINK, CAL. 30	D5503930	
5	MARK, MANUFACTURER'S IDENTIFICATION	C5559517	
6			
7			
8			
9			
10			

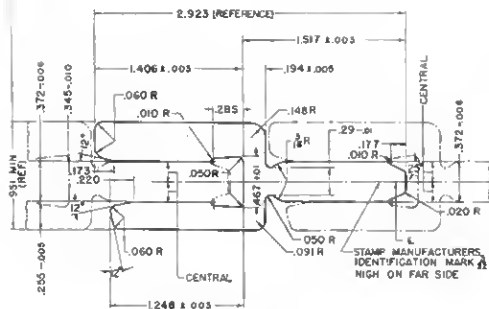
LINE NO.	LIST OF SPECIFICATIONS	SPEC NUMBER	REVISION	
			SYM	DATE
1	LINK, METALLIC BELT, CAL. 30, MI			
2	RIA PURCHASE DESCRIPTION	RIAP0338		
3				
4				
5				
6				
7	STEEL STRIP FOR METALLIC BELT LINKS	57-136-1		
8	FINISHES PROTECTIVE FOR IRON & STEEL PARTS	57-0-2		
9				

⊕ THIS SPEC IS NOT MANDATORY-SEE SPEC AIAFD636 LATEST REVISION

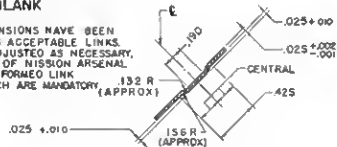
STRETCHED DURING FORMING,
BASED UPON SCRAPPLESS DIE METHOD

NOTES,
WITH CONNECTING AND BODY LOOPS TANGENT TO
A FLAT SURFACE, EDGES OF WINGS MUST NOT TOUCH
THE SURFACE.

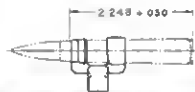
WEIGHT OF 100 LINKS .96 LBS
WEIGHT OF 100 CARTRIDGES IN LINKS 0.25 LBS



NOTE:
THE BLANK DIMENSIONS HAVE BEEN
USED IN MAKING ACCEPTABLE LINKS.
THEY MAY BE ADJUSTED AS NECESSARY,
UPON APPROVAL OF NISSION ARSENAL
FOR GIVING THE FORMED LINK
DIMENSIONS WHICH ARE MANDATORY. 13

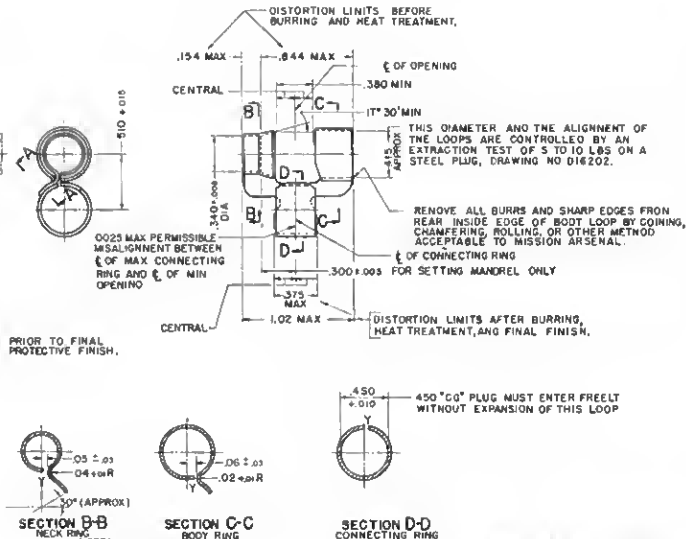


SECTION A-A



POSITION OF LINK ON CARTRIDGE

SCALE †



SECTION B-B

SECTION C-C

SECTION D-D
CONNECTING RING

NOTE: SECTIONS OF LINK AT "T" MAY BE FOLDED TO CONTACT OR LEFT WITH GAPS NOT TO EXCEED $\frac{1}{8}$

31, GENERAL REVISION	11-44-82	<i>[Signature]</i>
30, GENERAL REVISION	10-20-82	<i>[Signature]</i>
29, GENERAL REVISION	8-28-82	<i>[Signature]</i>
28, GENERAL REVISION	8-29-81	<i>[Signature]</i>
27, GENERAL REVISION	5-22-81	<i>[Signature]</i>
26, GENERAL REVISION	3-8-81	<i>[Signature]</i>
25, WAS C59722	10-24-80	<i>[Signature]</i>

[illegible]

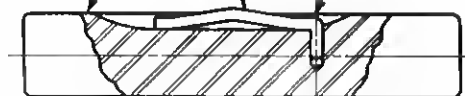
ORDNANCE DEPT
DEPT OF THE ARMY
ROCK ISLAND ARSENAL

HEAT TREATMENT AND FINAL FINISH

SPRING-A5020615

PIN-A5020562

EDGE OF SLOT TO BE PEENED
OVER TO RETAIN SPRING

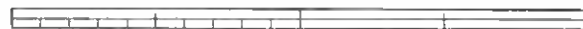


PIN ASSEMBLY

6131253

0

1 INCH



PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JUNE 1, 1931

REVISIONS

8 5-10-48
9 11-15-49

DRG. PERTAINS TO

51-10-41 30 BMG
M17A1 (WC)
51-83-1 30 BMG
M19A4 (FXD)
51-84-1 30 BMG
M19A4 (FLE)
51-114-1 30 BMG
M19A5 (FXD)
51-125-1 30 BMG
M19A6

DO NOT INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNED BY: S.C.F. L.R.E. C.E. CHIEF DRAFTSMAN
CHECKED BY: S.C.F. L.R.E. C.E. CHIEF DRAFTSMAN

SUBMITTED: A.H. ROE
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE: Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

WAS 6131253

B 6131253

B6131253

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A 5020562

FEB. 1, 1927

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

C38-43

REVISIONS

15 5-10-48

DRG. PERTAINS TO

B6131253

30 BMS
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR \pm

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

L.D.G. DRAFTSMAN

CHECKER

L.S.E.

CHIEF DRAFTSMAN

O.O.

SUBMITTED:

A.H. Roz

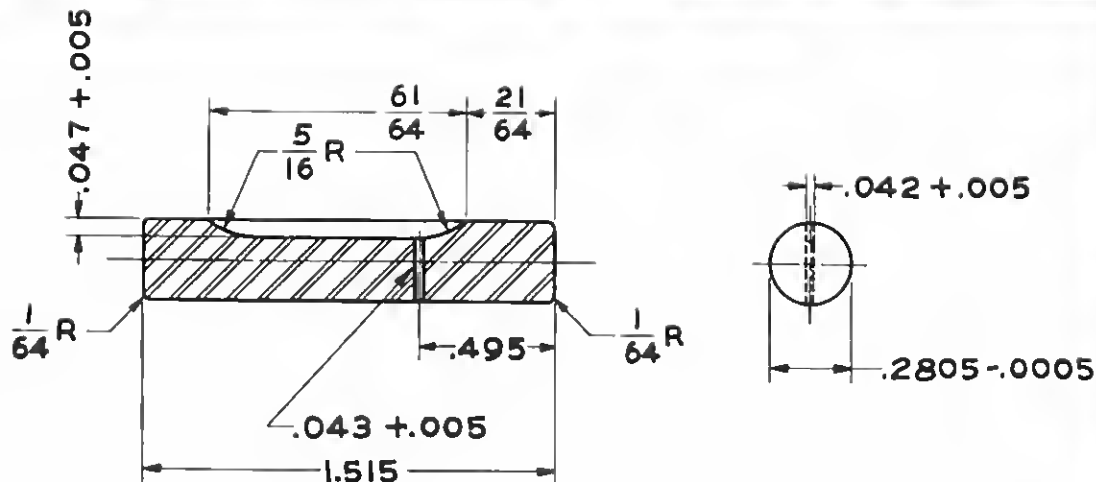
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



PIN
DRILL ROD
FINISH 125

5020562

WAS A20562

SCALE $\frac{2}{1}$

A

5020562

PHYSICAL PROPERTIES

A5020615

ROCK.

BR.

ORG. PERTAINS TO CONT.

50 M.G.-M3 AC. BASA

ALL 50BMG-M2

9	11-5-41	15 ⁴	1-9-46
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10	7-23-42	16	4-30-48
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11 ²	7-30-42	17 ²	CONVERSION 11-23-48
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122	3-13-43	182	2-15-49
-----	---------	-----	---------

13'	2-7-44		
-----	--------	--	--

14	2-10-45		
----	---------	--	--

DR'G. PERTAINS TO

T ALL 30 BMG

51-70 22 USMG MI

~~A5013440 PIN, ACCELERATOR, ASM~~

A13440	PIN BREECH LOCK ASM
--------	---------------------

A5013441	WIN, BELT FEED DAWL AS
----------	------------------------

ALL 2014	PIN, LOWER GOLD ISM
ALL 2014	PIN, LOWER GRIP ISM

B6131253 PIN ACCELERATOR ASSY

[illegible]

86/3/255	IN, BELT FEED TANG, 2
----------	-----------------------

~~ALL LOCAL MG.~~

B6147762	FN COCKING LEVER AS
----------	---------------------

B7313745 | PIN COCKING LEVER AS

1. SMAN	TRACER	LOG OPTSMAN
---------	--------	-------------

CHIEF CLERK

75A 00

SUBMITTED Eva

10/11/12 3:15

LT COL ORR DEPT U.S.

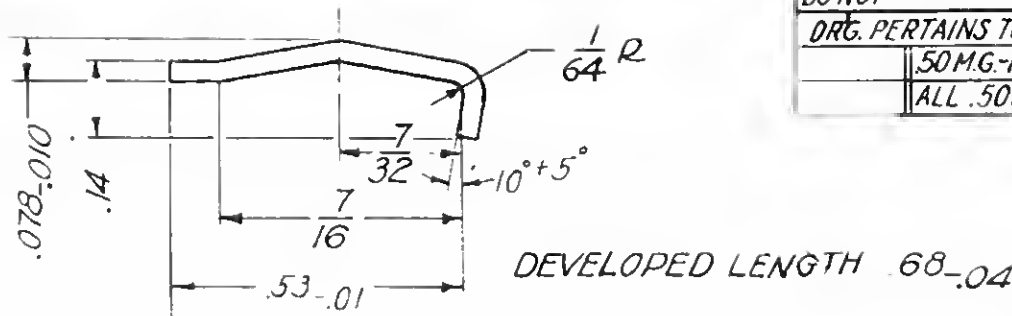
APPROVED BY ORDER OF THE

CHIEF OF ORDNANCE: *[Signature]*

77-2-200000
CASE-000-DEPT. U.S.A.

ORDNANCE DEPT. U. S. A.

ORDNANCE DEP'T, U. S. A.
CIRCULARS OF 1961



.037 (NO. 16) U.S. GAGE

- ⊕ SPRING, COCKING LEVER PIN
- ⊕ SPRING, ACCELERATOR PIN
- ⊕ SPRING, BELT FEED PAWL PIN
- SPRING, BREECH LOCK PIN
- ⊕ SPRING, LOWER GRIP PIN

5020615

~~(A20615-16)~~

SPRING STEEL WIRE WD1085 SPECIAL
U.S.A. SPEC 48-7-1

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING A20615
UNDER REVISION DATE OF NOV. 5, 1941

SCALE 4

A5020615

~~A20615~~

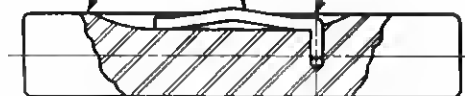
CHICAGO POLICE 12061

HEAT TREATMENT AND FINAL FINISH

SPRING-A5020615

PIN-A5020562

EDGE OF SLOT TO BE PEENED
OVER TO RETAIN SPRING

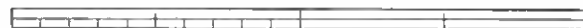


PIN ASSEMBLY

6131253

0

1 INCH



PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL

JUNE 1, 1931

REVISIONS

8 5-10-48
9 11-15-49

DRG. PERTAINS TO

51-10-41 30 BMG
M17A1 (WC)
51-83-1 30 BMG
M19A4 (FXD)
51-84-1 30 BMG
M19A4 (FLE)
51-114-1 30 BMG
M19A5 (FXD)
51-125-1 30 BMG
M19A6

DO NOT INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNED BY: S.C.F. TRACED BY: L.R.E. C.C. DRAFTSMAN
CHECKED BY: S.C.F. C.C. CHIEF DRAFTSMAN

SUBMITTED: A.H. ROE
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE: Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

WAS 8131253

B 6131253

B6131253

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

JUNE 1, 1931

REVISIONS

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

8 5-10-48
9 11-15-49

DRG. PERTAINS TO

E5509177 30 BMG
M17A1 (WC)
E5564096 30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

DO INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNED BY E.C.P. CHECKED BY L.R.E. D.D. L.S.G. DRAFTER
CHIEF DRAFTER

SUBMITTED:

H.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter

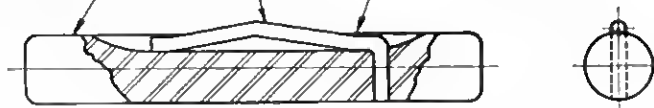
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

SPRING-A5020615
PIN-A5020491

EDGE OF SLOT TO BE PEENED
OVER TO RETAIN SPRING



PIN, BELT FEED PAWL, ASSEMBLY

6131255

0

1/2 INCH



WAS B131255

B 6131255

B6131255

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A 5020491

APRIL 4, 1927

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

C38-43

REVISIONS

12 5-10-48

DRG. PERTAINS TO

B6131255

30 BMG
M 17A1 (WC)
M 19A4 (FXD)
M 19A4 (FLEX)
M 19A5 (FXD)
M 19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR \pm

DRAFTSMAN

M.E.B.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.B.F.

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

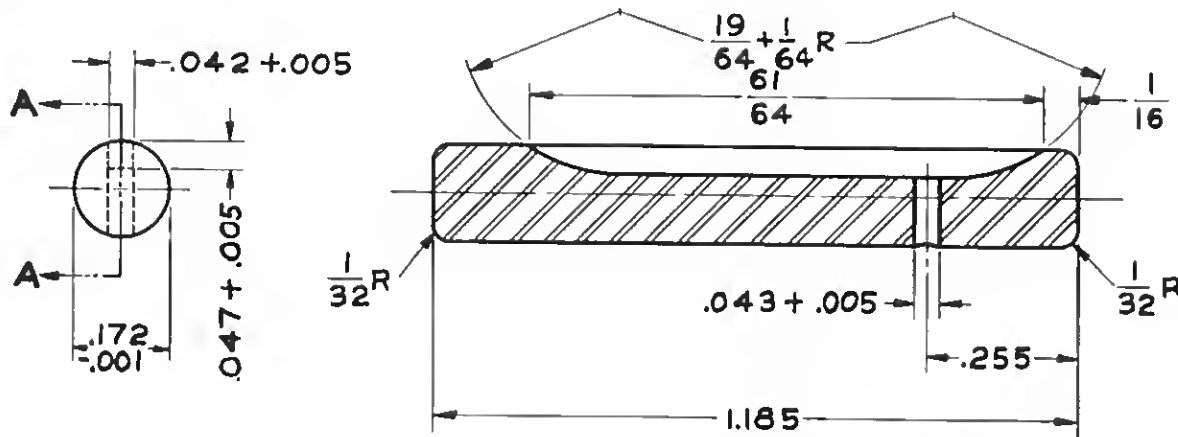
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



SECTION A-A

PIN, BELT FEED PAWL

DRILL ROD
FINISH 125/

5020491

WAS A20491

SCALE $\frac{4}{1}$

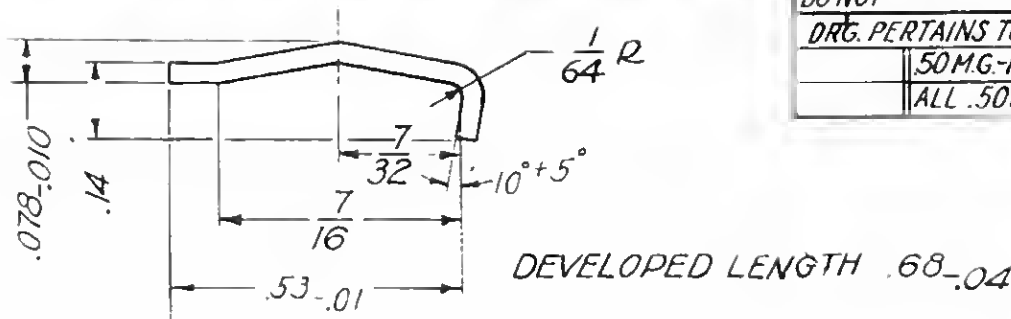
A

5020491

HEAT TREATMENT & FINAL FINISH
AFTER BENDING HEAT AT 450°-470°F FOR 15
MINUTES
PROTECTIVE FINISH TYPE I CLASS 0.S.C.

PHYSICAL PROPERTIES			
Y.P.		RED.	
T.S.		BR.	
EL 2			
DO NOT INSCRIBE PART NO.			
DRG. PERTAINS TO CONT.			
50MG-M3 AC BUR			
ALL 50BMG-M2			

APRIL 4, 1927			
REVISIONS			
9	11-5-41	15 ⁴	1-9-46
10	7-23-42	16 ²	4-30-48
11	7-30-42	17 ²	CONVERSION 11-23-48
12	3-13-43	18 ²	2-15-49
13	2-7-44		
14	2-10-45		



- ⊕ SPRING, COCKING LEVER PIN
- ⊕ SPRING, ACCELERATOR PIN
- ⊕ SPRING, BELT FEED PAWL PIN
- ⊕ SPRING, BREECH LOCK PIN
- ⊕ SPRING, LOWER GRIP PIN

SPRING STEEL WIRE WD1085 SPECIAL
U.S.A. SPEC 48-7-1

TOLERANCE ±.01 ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING A20615
UNDER REVISION DATE OF NOV. 5, 1941

SCALE $\frac{4}{1}$

5020615

A20615-16

A5020615

A20615

DR'G. PERTAINS TO			
			ALL 30 BMG
			51-78 22 USMG-MH
⊕	A5013440	PIN, ACCELERATOR ASM.	
⊕	A13440	PIN, BREECH LOCK ASM.	
⊕	A5013441	PIN, BELT FEED PAWL ASM.	
⊕	A22914	PIN, LOWER GRIP ASM.	
⊕	B6131253	PIN, ACCELERATOR ASM.	
⊕	B6131253	PIN, BREECH LOCK ASM.	
⊕	B6131255	PIN, BELT FEED PAWL ASM.	
			ALL 50 CAL MG
	B6147762	PIN, COCKING LEVER ASM.	
	B7013745	PIN, COCKING LEVER ASM.	
1 ST MAN	TRACER	LOG OFFICER	
FE	WLC	B.P.O.	
		CHIEF OFFICER	
		M.A.	00
SUBMITTED			
L.T. COL. ORD DEPT. U.S.			
APPROVED BY ORDER OF THE			
CHIEF OF ORDNANCE			
CAPT. ORD. DEPT. U.S.A.			
ORDNANCE DEPT., U.S.A.			

SUPERSEDES A 20615

A5020615

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

JUNE 1, 1931

REVISIONS

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

8 5-10-48
9 11-15-49

DRG. PERTAINS TO

E5509177 30 BMG
M17A1 (WC)
E5564096 30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

DO INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNED BY E.C.P. CHECKED BY L.R.E. D.D. U.S. G. DRAFTER
CHIEF DRAFTER

SUBMITTED:

H.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter

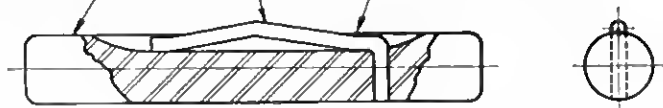
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

SPRING-A5020615
PIN-A5020491

EDGE OF SLOT TO BE PEENED
OVER TO RETAIN SPRING



PIN, BELT FEED PAWL, ASSEMBLY

6131255

0

1/2 INCH

WAS B131255

B 6131255

B6131255

HEAT TREATMENT AND FINAL FINISH

JUNE 1, 1931	
PHYSICAL PROPERTIES	REVISIONS
T P	10 5-10-48
T S	
EL #	
RED	
BR	
ROCK	
SCL	

DRG. PERTAINS TO

51-10-1	30 BMG M19A1 (WC)
51-83-1	30 BMG M19A2 (FXD)
51-84-1	30 BMG M19A2 (PLS)
51-114-1	30 BMG M19A2 (FXD)
51-125-1	30 BMG M19A2



PIN-C5508462

SPRING-86147229

PIN-AZ0498



PIN, FIRING, ASSEMBLY 5509186

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL: .0005
FRACTIONAL: 1/16
ANGULAR: 1/2

C.S. L.R.

SUBMITTED

H.H. Roe

WAS C9186

DO NOT INSCRIBE PART NO.

C5509186

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE
H.H. Roe

ORDNANCE DEPT., U. S. A.

U.S. GPO: 1931-10-10-10000



C5509186

[illegible]

HEAT TREATMENT AND FINAL FINISH

DRAW AT 450°F.
TYPE I FINISH, CLASS O9C
BAKE ONE HOUR AT 300-350°F.

DIAMETER OF WIRE	.0414
TOTAL NUMBER OF COILS	50.
OUTSIDE DIAMETER, FREE	.259±.003
MAX. OUTSIDE OIA AT MIN. OPERATING HEIGHT	.265
FREE LENGTH	4.28±.06
TYPE OF ENDS	50 & GD
WOUND	R.H.
MEAN ASSEMBLED HEIGHT	2.46
MIN. LOAD AT MEAN ASSEMBLED HEIGHT	15.5 LB
MIN. OPERATING HEIGHT	2.376
MIN. LOAD AT MIN. OPERATING HEIGHT	16.20 LB
LB PER INCH OF SPRING DEFLECTION	6.5
SPRING FUNCTIONS IN HOLE	.270
CALCULATED MAX. SOLID HEIGHT	2.07

CAUTION: DO NOT COMPRESS SOLID

NOTE:

.5% OF SPRINGS WILL BE FATIGUE TESTED
BETWEEN ASSEMBLED HEIGHT AND MINIMUM
OPERATING HEIGHT FOR 50,000 CYCLES. THE
LOAD AT ASSEMBLED HEIGHT, AFTER TESTING,
SHOULD NOT BE LESS THAN 14.5 LB

SPRING, FIRING PIN
SPRING STEEL WIRE WD1085 SPECIAL-CLASS A

G147229

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

FEBRUARY 1, 1938

REVISIONS

10	5-10-48		

DRG. PERTAINS TO

B 4755 .22 TRAINER
5500186 30 BMG
M17A1(WC)
M19A4(FXD)
M19A4(FLEX)
M19A5(FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL: —
FRACTIONAL: —
ANGULAR: —

W.L.M.	MN	1/8" DEPTH
		1/8" DEPTH

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT., U. S. A.

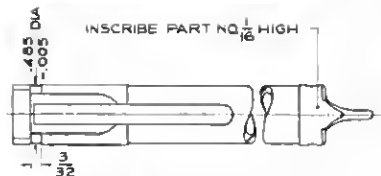
ORDNANCE DEPT., U. S. A.

WAS B147229

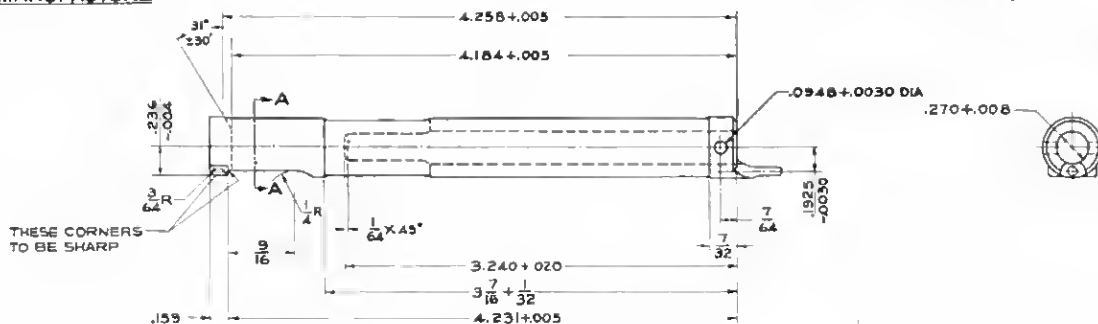
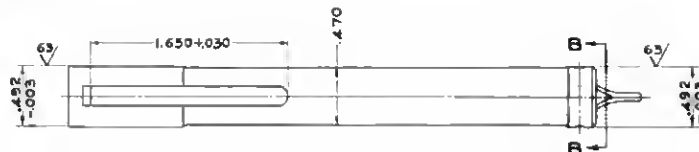
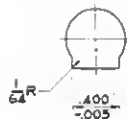
B | G147229

BG147229

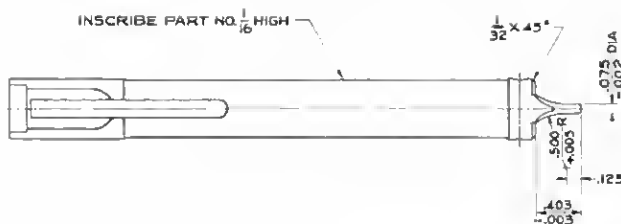
HEAT TREAT
TYPE II FINISH, CLASS B



ALTERNATIVE METHOD OF MANUFACTURE

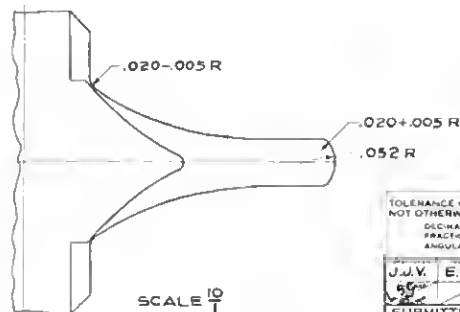


SECTION A-A



PIN, FIRING
STEEL F54140
FINISH 125/

550846Z

SCALE $\frac{10}{1}$

WAS CB462

INSTRUMENT PART NO.

SCALE $\frac{2}{1}$

C 5508462

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		23	6-10-48
T. S.			
EL. #			
AKD.			
BR.			
MOCK	C48-53		
SCL.			
		DRG. PERTAINS TO	
		5509/86	
		10 BMG	
		M19A1 (WC)	
		30 BMG	
		M19AA (FXD)	
		30 BMG	
		M19A4 (FLX)	
		30 BMG	
		M19A3 (FAD)	
		30 BMG	
		M19A6	

DRG. PERTAINS TO

25509186	30 BMG
	M19A1(WC)
	30 BMG
	M19A4(FXD)
	30 BMG
	M19A4(FLYX
	30 BMG
	M19A5(FXD)
	30 BMG
	M19A6

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL : .005
FRACTIONAL : 1/64
ANGULAR : 5°

J. V. E. B.

SUBMITTED

DATE: 1/10/2018

7/11/02

APPROVED BY ORDER OF THE COURT
OF DISTRICT

John C. Korman

ORDNANCE DEPT U S A

MADE IN U.S.A. - BLANK AND UNWRITTEN

HEAT TREATMENT AND FINAL FINISH

JUNE 1, 1931	
PHYSICAL PROPERTIES	REVISIONS
Y P	10 5-10-48
Y S	
EL 2	
RED	
BR	
ROCK	
SCL	

DRG. PERTAINS TO

51-10-1	30 BMG M 1911 (WC)
51-83-1	30 BMG M 1918 (FXD)
51-84-1	30 BMG M 1918 (PLS)
51-114-1	30 BMG M 1918 (FXD)
51-125-1	30 BMG M 1918



PIN-C5508462

SPRING-86147229

PIN-AZ0498



PIN, FIRING, ASSEMBLY 5509186



TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL: .0005
FRACTIONAL: 1/64
ANGULAR: 1/2

DATE	BY	REVISION
5/10/48	W. H. R.	1

SUBMITTED

A. H. Roe

ORD. DEPT. U. S. A.

WAS C9186

DO NOT INSCRIBE PART NO.

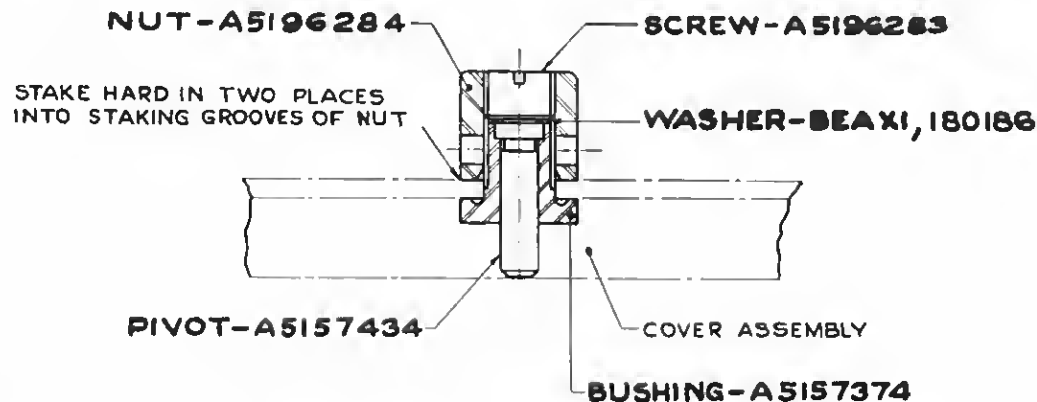
5509186

ORDNANCE DEPT., U. S. A.

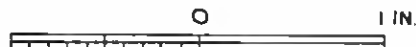
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C5509186

HEAT TREATMENT AND FINAL FINISH



PIVOT, BELT FEED LEVER, GROUP ASSEMBLY (6110529



PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JULY 18, 1941

REVISIONS

4 5-10-48

DRG. PERTAINS TO

C5509177 50 BMO
M 17A1 (WC)
C5564096 50 BMO
M 19A4 (FXD)
M 19A4 (FLEX)
M 19A5 (FXD)
M 19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

REVIEWER	FILED	1-10-48
SOLICITOR	O.K.	1-10-48
ENGINEER	S.A.	1-10-48

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B 110529

B 6110529

B6110529

A 5157374

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

SEPT. 30, 1936

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

C.C.

.007 TO .010
DEEP

EL. 2

ROCK

REVISIONS

13 5-10-48

DRG. PERTAINS TO

B6110529

30 BMG
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

R.J.L.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.S.P.

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

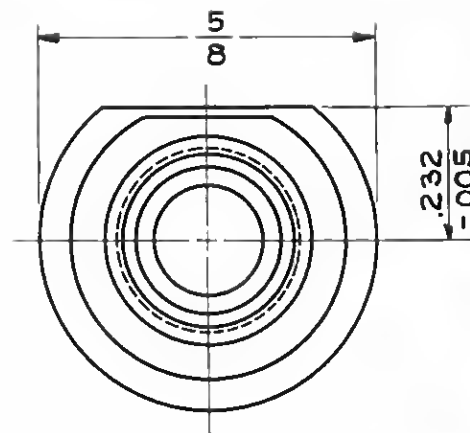
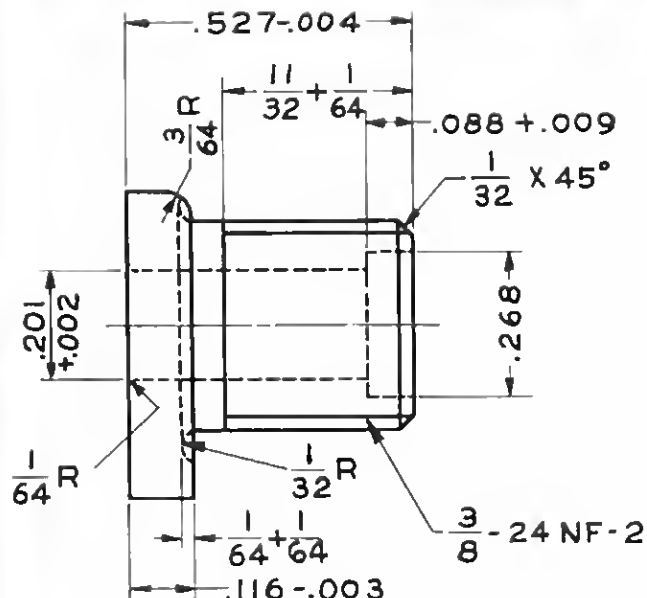
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



BUSHING, BELT FEED LEVER PIVOT

STEEL FS X1020

FINISH 125/

5157374

WAS A157374

SCALE 4/1

A

5157374

A 5157434

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

SEPT. 30, 1936

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL

T. S.

BR.

C. C.

0.12 TO 0.18
DEEP

EL. 2

ROCK

REVISIONS

12 5-10-48

DRG. PERTAINS TO

B6110529

30BMG
M17A1 (WC)
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{64}$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

R. J. L.

TRACER

E. R. G.

L'O'G DRAFTSMAN

CHECKER

J. S. L.

CHIEF DRAFTSMAN

SUBMITTED:

A. H. Poe

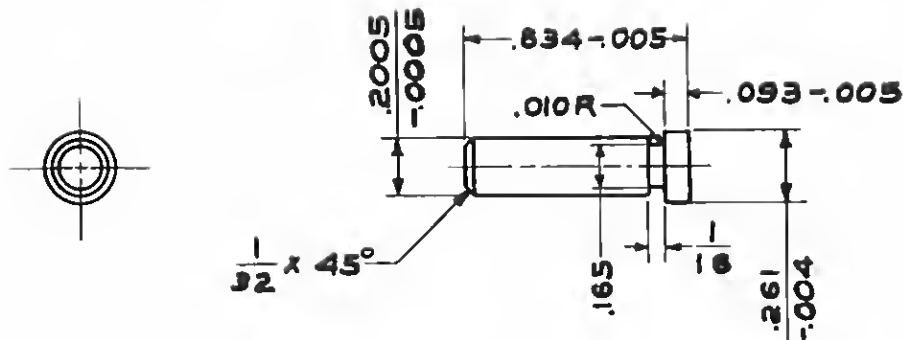
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



PIVOT, BELT FEED LEVER

STEEL FS3115

FINISH 125/

5157434

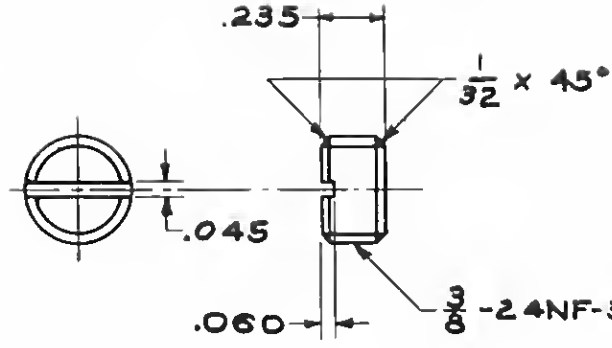
WAS A157434

SCALE $\frac{2}{1}$

A

5157434

1596283

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						JULY 18, 1941											
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.		RED.		SCL		REVISIONS											
		T. S.		BR.		C. A.	.005 TO .007 DEEP	9	510-48										
		EL. 2		ROCK															
<div></div> <div><p>SCREW, BELT FEED LEVER PIVOT</p><p><u>STEEL FSX1315</u></p><p>5196283</p></div> <div><p>SCALE $\frac{2}{1}$</p><p>A</p><p>5196283</p></div>												DRG. PERTAINS TO B6110529				M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6			
INSCRIBE PART NO. DO NOT																			
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .008$ FRACTIONAL $\pm \frac{1}{84}$ ANGULAR $\pm 3^\circ$																			
DRAFTSMAN L.E.S.		TRACER ERG		L'D'S DRAFTSMAN		CHECKED 		CHIEF DRAFTSMAN		SUBMITTED: 									
										ORD. DEPT., U. S. A.									
										APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: 									
										ORD. DEPT., U. S. A.									
										ORDNANCE DEPT., U. S. A.									

A5196284

HEAT TREATMENT & FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES

Y. P.		RED.		SCL.	
T. S.		BR.			
EL. 2		ROCK	C30-35		

JULY 18, 1941

REVISIONS

11 5-10-48

DRG. PERTAINS TO

B6110529

SO SMC
M17A1(WC)
M19A4(FLEX)
M19A4(FXD)
M15A5(FXD)
M17A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .010$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN L.E.S.	TRACER LRE	L.D.G. DRAFTSMAN
CHECKER J.F. <i>Butt</i>	O.O.	CHIEF DRAFTSMAN

SUBMITTED:

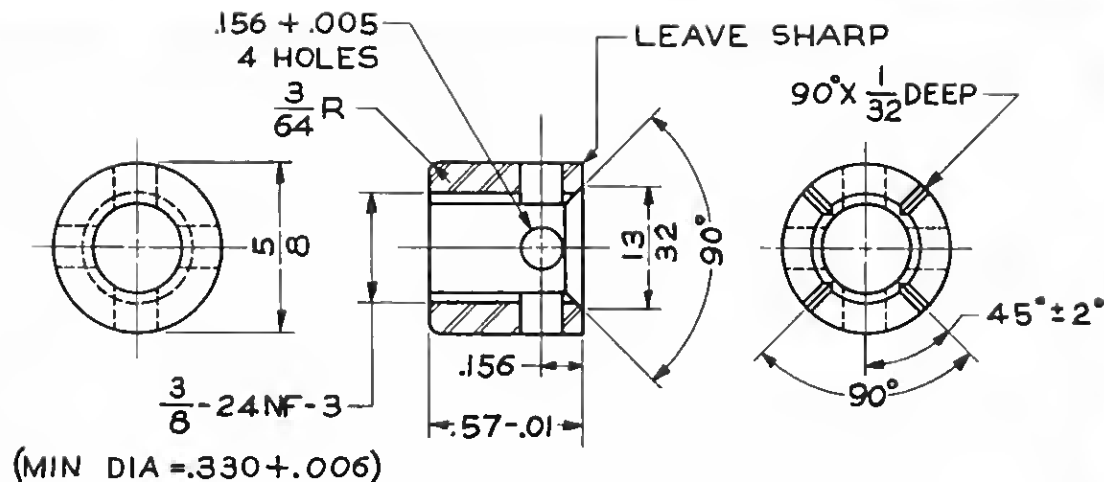
A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter A. Schuman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

NUT, BELT FEED LEVER PIVOT BUSHINGSTEEL FS 1045FINISH 125/

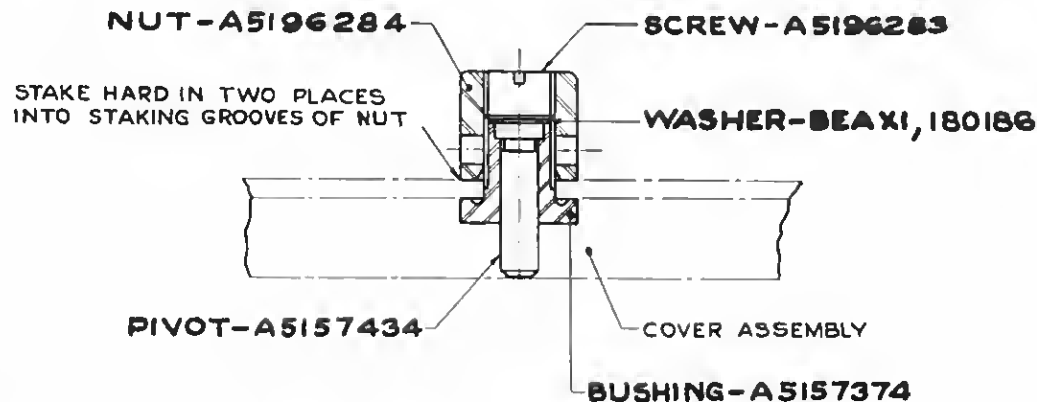
5196284

WAS A196284

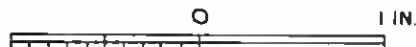
SCALE $\frac{2}{1}$

A 5196284

HEAT TREATMENT AND FINAL FINISH



PIVOT, BELT FEED LEVER, GROUP ASSEMBLY (6110529



PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JULY 18, 1941

REVISIONS

4 5-10-48

DRG. PERTAINS TO

C5509177 50 BMO
M17A1(WC)
C5564096 50 BMO
M19A4(FXD)
M19A4(FLEX)
M19A5(FXD)
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

REVIEWER	DESIGN	CHECK DESIGNS
SOLICITOR	O.K.	CHECK DESIGNS
ENGINEER	S.A.	CHECK DESIGNS

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter A. ...
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B 110529

B 6110529

B6110529

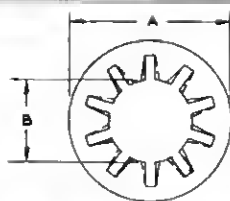
WASHER, LOCK, "TOOTH" TYPE INTERNAL TOOTH

BEAXI

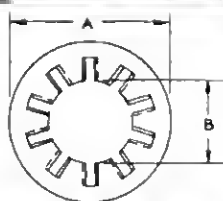
ORDNANCE DEPARTMENT STANDARDS (COMMERCIAL)

APPROVED

5-11-33
DATE



TYPE A



TYPE B

SIZE, NOMINAL		#2	#3	#4	#5	#6	#8
A OUTSIDE DIAMETER	MAX. MIN.	.200 .175	.232 .215	.270 .255	.280 .245	.295 .275	.340 .325
B INSIDE DIAMETER	MAX. MIN.	.095 .069	.109 .102	.123 .115	.136 .129	.150 .141	.176 .168
C THICKNESS	MAX. MIN.	.015 .010	.019 .012	.019 .015	.021 .017	.021 .017	.023 .018

MATERIAL AND FINISH	ORDNANCE PART NUMBER
STEEL PLAIN	190638
STEEL CADMIUM OR ZINC PLATED	188131
STEEL NICKEL PLATED	180088
STEEL CHROMIUM PLATED	180049
STEEL PHOSPHATE COATED	180090
STEEL TIN PLATED	583140
STEEL STAINLESS	221117
PHOSPHOR BRONZE PLAIN	424227
PHOSPHOR BRONZE TINNED	228809
	424219
	424220
	424221
	219091
	225843

SIZE, NOMINAL		#12	#12	#14 & 1/4	5/16	3/8
A OUTSIDE DIAMETER	MAX. MIN.	.381 .365	.410 .394	.478 .460	.610 .594	.692 .670
B INSIDE DIAMETER	MAX. MIN.	.204 .195	.231 .221	.267 .256	.332 .320	.398 .384
C THICKNESS	MAX. MIN.	.025 .020	.025 .020	.028 .023	.034 .028	.040 .032

MATERIAL AND FINISH	ORDNANCE PART NUMBER
STEEL PLAIN	115545
STEEL CADMIUM OR ZINC PLATED	121801
STEEL NICKEL PLATED	118926
STEEL CHROMIUM PLATED	135533
STEEL PHOSPHATE COATED	130534
STEEL TIN PLATED	225804
STEEL STAINLESS	583153
STEEL LEAD PLATED	221199
STEEL BLACK OXIDE	225804
PHOSPHOR BRONZE PLAIN	190672
PHOSPHOR BRONZE TINNED	424222
PHOSPHOR BRONZE NICKEL PLATED	228832
	424223
	228834
	424224
	502290
	190676
	424225
	213535

MATERIAL:

STEEL - SAE 1050 OR 1066 HEAT TREATED, ROCKWELL HARDNESS C40 - C50 OR EQUIVALENT.
PHOSPHOR BRONZE - SPECIFICATION QQ-B-746.

NOTE: FOR SPECIFICATIONS, SEE DRAWING BEAX10.

NOMENCLATURE PATTERN: WASHER, LOCK, TOOTH TYPE, STEEL, 3/8" (PLAIN), DRG. BEAX1, PART NO. 115549.

NOTE: EITHER TYPE A OR TYPE B IS ACCEPTABLE.

51-84-1
51-125-1

DISK-A9374
PLUNGER-A5135052
SPRING-A5135053

-SCREW-BCLX3,503955
-WASHER-BEAX4,138595
-SPRING-A513996\$

7100059

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL _____
FRACTIONAL _____
ANGULAR _____

DATE	TIME	BY
RJM	ZC	

SUBMITTED

4/18/08

DO NOT INSCRIBE PART NO

C 7100059

APPROVED BY ORDER OF THE CHIEF
OF ORIGINALE

ORDNANCE DEPT., U. S. A.

SUPERSEDES C7100059 WO/C 8-19-48



A 5020581

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 1, 1931

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

E. L. 2

ROCK

C43-49

REVISIONS

17 5-10-48

DRG. PERTAINS TO

C5591794

30 BMG
M17A1 (WC)

C5621039

30 BMG
M19A4 (FXD)
M19A6 (FXD)

C7100059

30 BMG
M19A4 (FLEX)
M19A6

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL \pm —FRACTIONAL \pm 1/64ANGULAR \pm 5°

DRAFTSMAN

W.C.O.

TRACER

A.V.C.

L'D'G DRAFTSMAN

CHECKER

S.E. R.R.

CHIEF DRAFTSMAN

SUBMITTED:

A.W. Roe

ORD. DEPT., U. S. A.

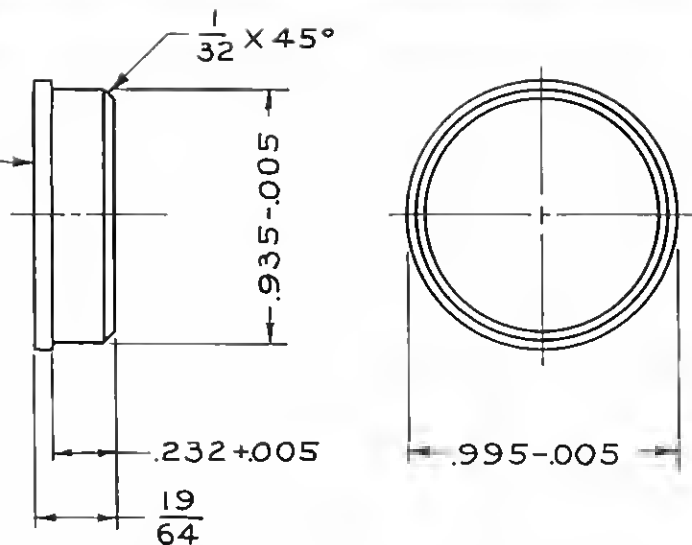
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

INSCRIBE PART NO.

PLATE, BUFFERSTEEL FS1045FINISH 125/
✓

(5020581)

SCALE $\frac{2}{1}$

WAS A20581

A 5020581

A5139969

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 26, 1936

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

A-73-76

REVISIONS

15 8-19-48

DRG. PERTAINS TO

C7100059

.30BMG
M19A4 (FLEX)
M19A6INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL \pm
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 2^\circ$ DRAFTSMAN
E.J.L.TRACER
O.K.

L'D'G DRAFTSMAN

CHECKED
C.E.F.

CHIEF DRAFTSMAN

SUBMITTED:

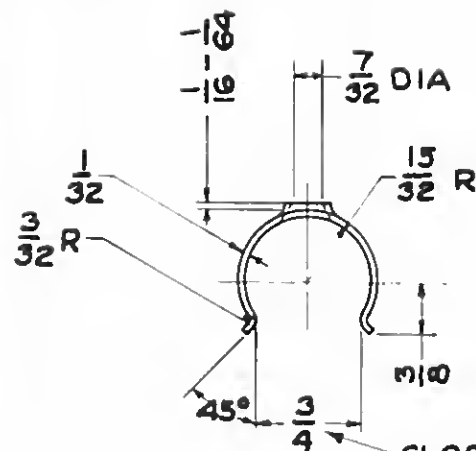
A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Schuman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

CLOSE SPRING TO THIS DIMENSION BEFORE
HARDENING
DEVELOPE LENGTH $2\frac{1}{2}$ IN. APPROXSPRING STOCK
STEEL WD1095

5139969

WAS A139969

SCALE $\frac{1}{1}$

A 5139969

A5135052

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 1, 1931

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

C.C.

EL. 2

ROCK

.004 TO

.006 DEEP

REVISIONS

17 8-19-48

DRG. PERTAINS TO

C5591794

C7100059

30 BNG

M17A1(WC)

30 BNG

M19A4(FLEX)

M19AG

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS

NOT OTHERWISE SPECIFIED

DECIMAL \pm —FRACTIONAL \pm $\sqrt{64}$ ANGULAR \pm —

DRAFTSMAN

W.C.Q.

TRACER

E.R.G.

L'D'G DRAFTSMAN

CHECKER

P.H.V.

C.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.W. Roe

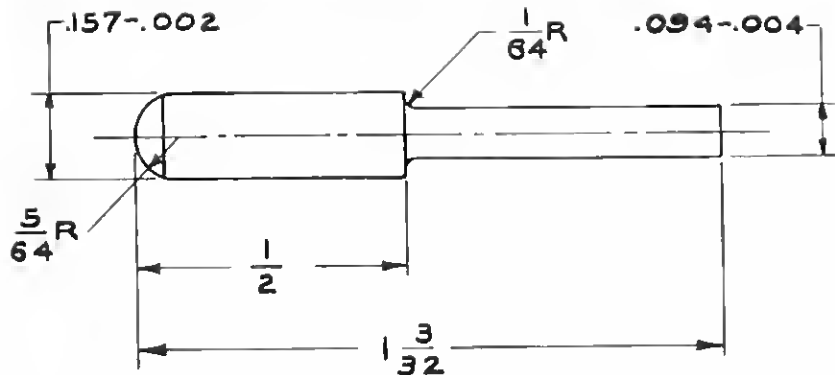
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

PLUNGER ADJUSTING SCREWSTEEL FSX1020FINISH $\sqrt{125}$

5135052

WAS A135052

SCALE $\frac{4}{1}$

A

5135052

A 5135053

JUNE 1, 1931

HEAT TREATMENT & FINAL FINISH

DRAW AT 450°F
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F

PHYSICAL PROPERTIES

Y. P.		RED.		SCL.	
T. S.		BR.			
EL. 2		ROCK			

REVISIONS

19	8-19-48		

DRG. PERTAINS TO

C5591794	30 BMG M17A1 (WC)
C7100059	30 BMG M19A4 (FLEX) M19A6

DIAMETER OF WIRE _____ .027
TOTAL NUMBER OF COILS _____ 15
MINIMUM INSIDE DIAMETER, FREE _____ .095
MAX. OUTSIDE DIA AT MIN OPER. HT _____ .159
FREE LENGTH _____ .83±.03
TYPE OF ENDS _____ SQUARED & GROUND
WOUND _____ R.H.
MEAN ASSEMBLED HEIGHT _____ .700
LOAD AT MEAN ASSEMBLED HT _____ 3.8LB±.5LB
MIN OPERATING HEIGHT _____ .669
LOAD AT MIN OPER HT _____ 4.7LB±.5LB
LB PER INCH OF SPRING DEFLECTION _____ 29 APPROX
SPRING FUNCTIONS IN HOLE _____ .160
SPRING FUNCTIONS OVER ROD _____ .094
CALCULATED MAX. SOLID HT _____ .450

CAUTION: DO NOT COMPRESS SOLID.

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± —
FRACTIONAL —
ANGULAR ± —

DRAFTSMAN W.L.M.	TRACER E.B.	L'D'G DRAFTSMAN
<i>W.L.M.</i>	<i>E.B.</i>	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SPRING, ADJUSTING SCREW PLUNGER (5135053)
SPRING STEEL WIRE
(WD1085 SPECIAL-CLASSA)

WAS A135053

A 5135053

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

DEC. 1, 1926

Y.P.

RED

SCL

T.S.

BR.

FL. 2

ROCK.

REVISIONS

12	7-5-39	16	12-20-41
13	10-19-39	17	6-17-42
14	7-1-40	18	7-7-42
15	8-27-41	19	11-2-43
20	1-13-44	21	3-27-44

DRG PERTAINS TO

C7100059 PLATE, BACK,

W/BUFFER, ASM

DRG. PERTAINS TO

ALL CAL 30BMG

51-78 22USMG-MI.

C64293 PLATE, BACK, SPAC

GRIP, ASSEMBLY

C64294 PLATE, BACK W/HOR

W/BUFFER, ASM

B17692 PLATE, BACK, ASM

C121039 PLATE, BACK

W/BUFFER, ASSEM.

C64010 PLATE, BACK / BUFFER

AND STOCK, ASSEMBLY

C91794 PLATE, BACK W/

BUFFER & STOCK, ASSEM.

D. F. SMITH

J. H. B. 3107

J. H. B. 3107

J. H. B. 3107

J. H. B. 3107

J. H. B. 3107

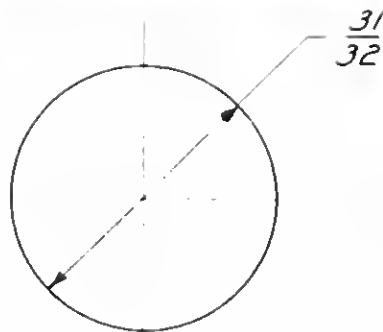
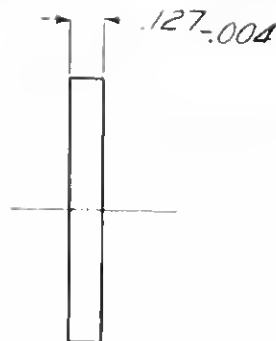
J. H. B. 3107

J. H. B. 3107

J. H. B. 3107

J. H. B. 3107

J. H. B. 3107

DISK, BUFFER (A-9374-3RED FIBREALL EDGES MUST BE SMOOTH
AND FREE FROM BURR & TEARS.TOLERANCE $\pm .01$ ALLOWED ON ALL DIMEN-
SIONS UNLESS OTHERWISE SPECIFIED.SUPERSEDES OLD TRACING A-9374
UNDER REVISION DATE OF JULY 5, 1939.SCALE $\frac{2}{1}$

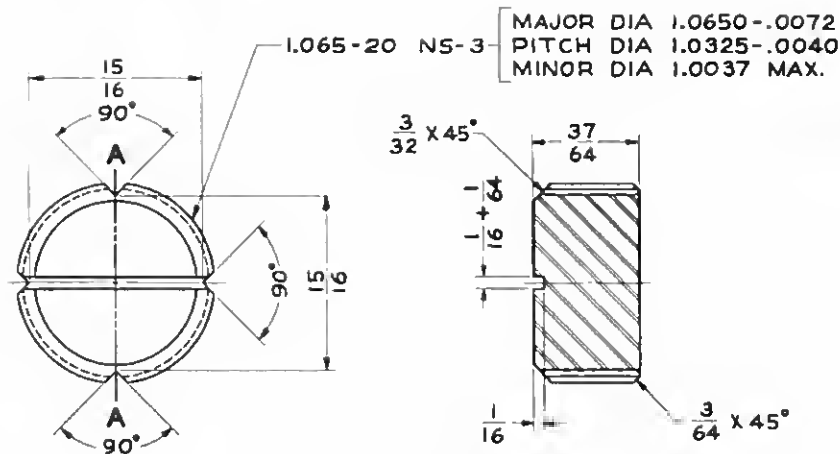
A 9374

MAJOR

J. H. B. 3107

ORD. 11

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B

SECTION A-A

SCREW, ADJUSTING

STEEL FS X1335

FINISH 125

6134059

PHYSICAL
PROPERTIESY. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.
C.C..004 TO .006
DEEP

JUNE 1, 1931

REVISIONS

20 8-19-48

DRG. PERTAINS TO

C5591794 30 BMG
M17A1(WC)
7100059 30 BMG
M19A4(FLEX)
M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: 1/64
ANGULAR: 5°

DESIGNED W.C.O.	TECHNICAL L.R.E.	CHIEF DRAFTER G.A.
--------------------	---------------------	-----------------------

SUBMITTED:

J.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. Anderson

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B134059

SCALE 2/1 B 6134059

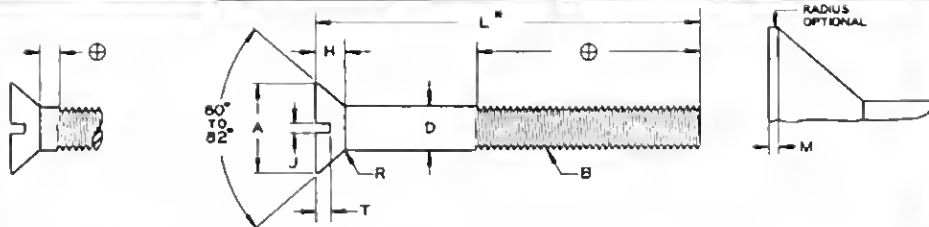
B6134059

SCREW, MACHINE, FLAT HD. (NF-3) COR. RES. STEEL

BCLX3

ORDNANCE DEPT. STANDARDS (ORDNANCE DESIGN)

APPROVED *Max* 5-15-31
DATE



NOMINAL SIZE	#0	#1	#2	#5	#8	#10		
B THREADS PER INCH	80	72	64	44	36	32		
D DIAMETER OF BODY	MAX. .0600 MIN. .0502	.0730 .0630	.0860 .0740	.1250 .1075	.1640 .1435	.1900 .1670		
A DIAMETER OF HEAD	SHARP MAX. .119 SHARP MIN. .105 ABS. MIN. .101	.146 .130 .126	.172 .156 .150	.252 .232 .225	.332 .308 .300	.325 .306 .348		
J WIDTH OF FLAT	MAX. .001 MIN. .001	.001 .001	.003 .003	.005 .005	.006 .006	.007 .007		
H HEIGHT OF HEAD	MAX. .035 MIN. .026	.041 .031	.051 .040	.075 .062	.100 .084	.111 .098		
T DEPTH OF SLOT	MAX. .023 MIN. .016	.028 .019	.031 .023	.041 .015	.054 .045	.060 .050		
R RADIUS	MAX. .025 MIN. .010	.027 .012	.031 .015	.045 .022	.055 .029	.062 .034		

L LENGTH	ORDNANCE PART NUMBER - STANDARDS - CORROSION RESISTING STEEL							
1/8		503932	503907					
3/16		503933	503908	544214	503951	544230		
1/4		503934	503909	503941	503952	503961		
5/16		503935	503910		503953	503962		
3/8		503936	503911	503942	503954	503966		
1/2					503955	503967		
5/8					503956	503963		
3/4					503957	503964		
7/8					503958	503965		
1					503959	503966		

L LENGTH	ORDNANCE PART NUMBER - LIMITED STANDARDS - CORROSION RESISTING STEEL							
1/16	503925	503937						
3/32	503926	503938	503943					
1/8	503927							
5/32	503928	503906	503944					
3/16	503929							
7/32								
1/4	503930			503950				
5/16	503931							
7/16				502298		544267		
1/2								
1-1/4					503960	503967		
1-3/16					541920			
1-1/2				582803		503968		

MATERIAL: STEEL, CORROSION RESISTING, GRADE 7A, SPEC. QQ-S-763, LATEST REVISION. DIMENSIONS IN INCHES.

NOMENCLATURE PATTERN: SCREW, MACHINE, FLAT HD., COR. RES. STEEL, #2 - 6ANF-3 x 1/2", DRG. BCLX3, PART NO. 503942.

LENGTH OF THREAD: ON SCREWS 2" LONG OR SHORTER, THREADS SHALL EXTEND TO WITHIN TWO THREADS OF THE BEARING SURFACE OF THE HEAD. LONGER LENGTHS SHALL HAVE A MINIMUM COMPLETE THREAD LENGTH OF 1-3/4".

* TOLERANCE ON LENGTH: UP TO 1" MINUS 1/32; OVER 1" TO 2" MINUS 1/16; OVER 2" MINUS 3/32.

NOTE: PROCURABLE FROM FRANKFORD ARSENAL. THESE SCREWS ARE PRIMARILY FOR INSTRUMENT WORK.

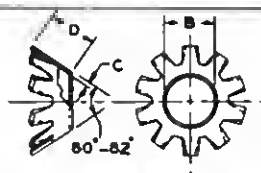
WASHER, LOCK "TOOTH" TYPE EXTERNAL TOOTH, COUNTERSUNK

BEAX4

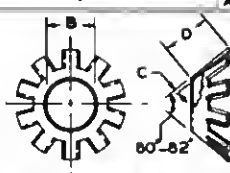
ORDNANCE DEPARTMENT STANDARDS (COMMERCIAL)

H3H
APPROVED

5-11-33
DATE



TYPE A



TYPE B

SIZE, NOMINAL		#4	#8	#8	#10	#12	#14 & 1/4
B INSIDE DIAMETER	MAX.	.123	.150	.177	.205	.231	.267
	MIN.	.113	.140	.167	.195	.220	.255
C THICKNESS	MAX.	.019	.021	.021	.025	.025	.025
	MIN.	.015	.017	.017	.020	.020	.020
D SIDE LENGTH	MAX.	.065	.092	.105	.099	.128	.128
	MIN.	.050	.062	.088	.083	.118	.113

MATERIAL	FINISH	ORDNANCE PART NUMBER					
STEEL	PLAIN	114611	114612	114613	114614	114615	114616
STEEL	CADMIUM OR ZINC PLATED	125817	138589	138593	138597	138600	138604
STEEL	NICKEL PLATED	125819	120155	120156	120157	120158	120152
STEEL	CHROMIUM PLATED	125818	138590	138594	129184	138601	138605
STEEL	PHOSPHATE COATED	125820	138591	138595	138598	138602	138606
STEEL	CORROSION RESISTING		431505	431506			

SIZE, NOMINAL		#16	5/16	3/8	7/16	1/2	
B INSIDE DIAMETER	MAX.	.287	.333	.398	.463	.529	
	MIN.	.273	.318	.383	.448	.512	
C THICKNESS	MAX.	.028	.028	.034	.045	.045	
	MIN.	.023	.023	.028	.037	.037	
D SIDE LENGTH	MAX.	.147	.192	.255	.270	.304	
	MIN.	.137	.165	.242	.260	.294	

MATERIAL	FINISH	ORDNANCE PART NUMBER					
STEEL	PLAIN	138608	114617	114618	114619	114620	
STEEL	CADMIUM OR ZINC PLATED	138609	134512	138617	125823	125829	
STEEL	NICKEL PLATED	138611	120159	120160	125825	125831	
STEEL	CHROMIUM PLATED	138610	138614	138618	125824	125830	
STEEL	PHOSPHATE COATED	138612	138615	138619	125826	125832	
STEEL	CORROSION RESISTING		583135				

MATERIAL:

STEEL - SAE 1050 OR 1066 HEAT TREATED, ROCKWELL HARDNESS C40 - C50 OR EQUIVALENT.

NOTE: FOR SPECIFICATIONS, SEE DRAWING BEAX10.

NOMENCLATURE PATTERN: WASHER, LOCK, "TOOTH" TYPE, COUNTERSUNK, 3/8", DRG. BEAX4, PART NO. 114618.

NOTE: EITHER TYPE "A" OR TYPE "B" IS ACCEPTABLE.

ENGINEERING & INSPECTION SECTION - GROUP

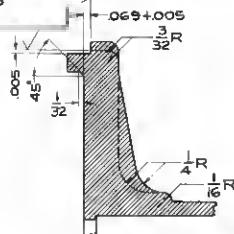
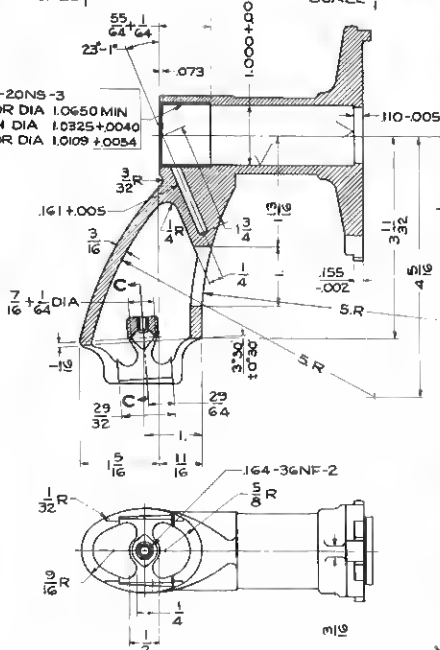
ORDNANCE DEPT. DRAWING BEAX4

REVISIONS: 7 11-6-46 6 9-8-49

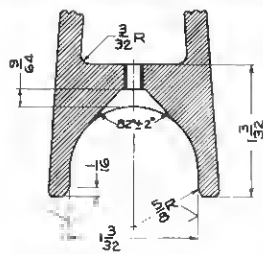
SUPERSEDES BEAX4 WITH CHANGE 11-8-46

SCALE $\frac{2}{1}$

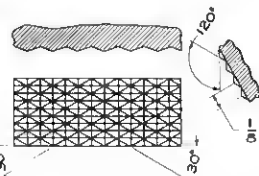
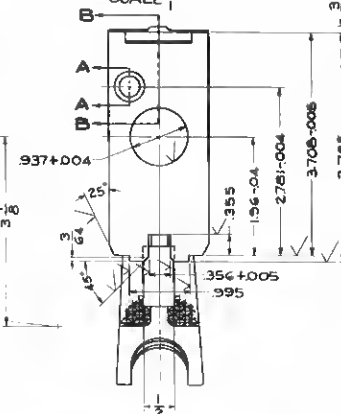
1.065-20NS-3
MAJOR DIA 1.0650 MIN
PITCH DIA 1.0325+0.040
MINOR DIA 1.0109 +0.054



SCALE 2

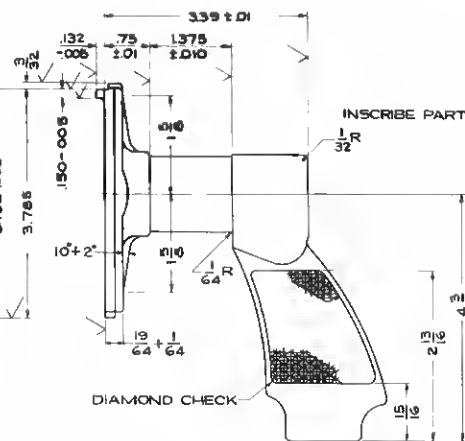
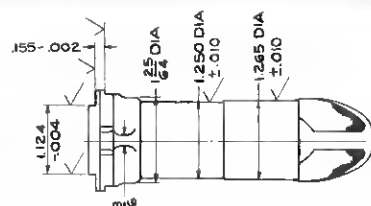


SCALE 1



VIEW DF DIAMOND CHECK

SCALE 2



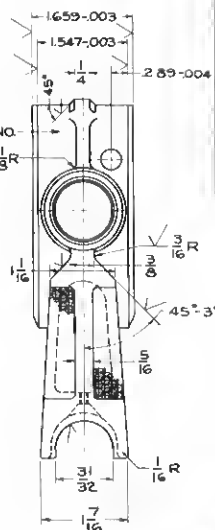
PLATE, BACK
PEARLITIC MALLEABLE IRON-CLASS A
FINISH ✓ TO BE 125 ✓

SCALE 1

PHYSICAL PROPERTIES		AUGUST 18, 1943	
		REVISIONS	
Y. P.		7	8-19-48
T. S.			
EL. Z.			
REQ.			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

C7100059	30 BING M1944 (FLEX) 30 BING M1946
----------	---



TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 5^\circ$

الاسم: B. J. M.	الرقم: Z. C.	التاريخ: 10/05/2023
------------------------	---------------------	----------------------------

SUBMITTED:

5th of

本報地址：中國廣東省佛山市江門區江門大道西1111號 電話：0750-3100000 傳真：0750-3100000 郵政編碼：529000

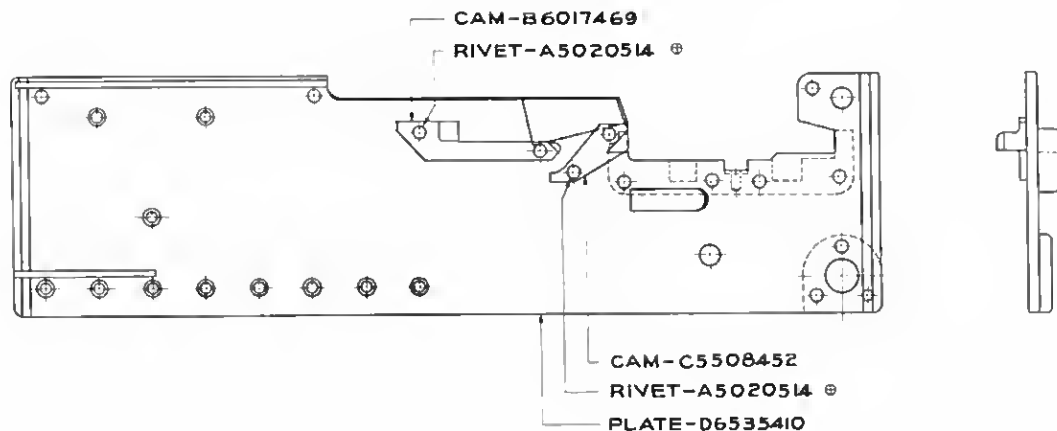
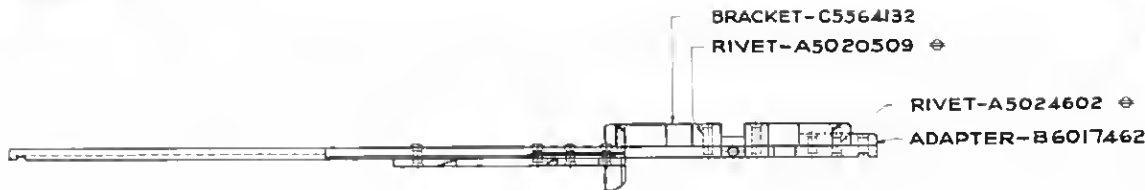
APPROVED BY ORDER OF THE CHIEF
OF DISTANCE

9/20/66 *W. L. L. L. L.*
O'D DEPI U S A

ORDNANCE DEPT., U. S. A.

DRG PERTAINS TO

06535358	30 BMG M19A2 (FXD) (FLEX)
06540989	30 BMG M19A2 (FXD)
07114037	30 BMG M19A2

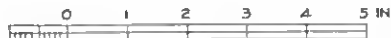


PLATE, SIDE, L.H., ASSEMBLY

5564222

NOTE:

- ⊕ GRIND FLUSH INSIDE
⊖ GRIND FLUSH INSIDE AND OUTSIDE



WAS C64222

C 5564222

APPROVED BY UNDER SECRETARY OF THE TREASURY
OF ORONANCE
Walter L. Anderson
AND DEPT. U. S. A.
ORONANCE DEPT., U. S. A.

C5564222

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A5020509

APRIL 4, 1927

REVISIONS

Y. P.

RED.

SCL.

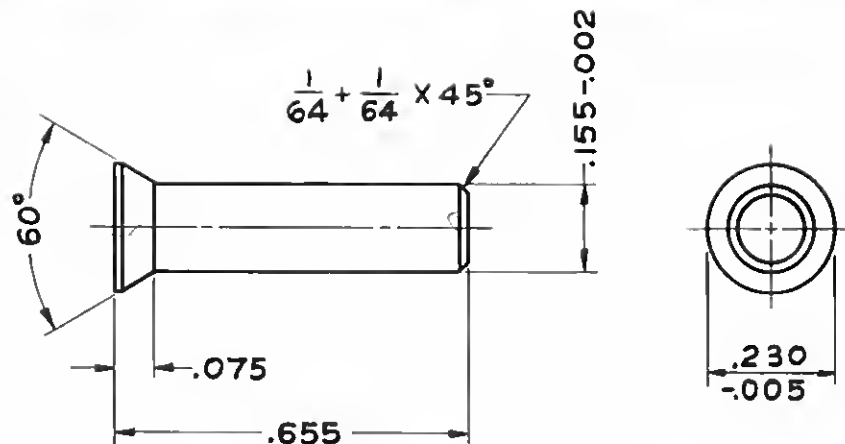
T. S.

BR.

EL. 2

ROCK

11 5-10-48

**RIVET, BELT HOLDING PAWL BRACKET****STEEL F51035****FINISH 125/**

5020509

WAS A20509

SCALE $\frac{4}{1}$

A

5020509

DRG. PERTAINS TO

C5564185

.30 BMG
M17A1 (WC)

C5564222

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{16}$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

L'D'S DRAFTSMAN

CHECKER

Jst. L.R.E.

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

A 5020514

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

APRIL 4, 1927

REVISIONS

Y. P.

RED.

SCL

T. S.

BR.

EL. 2

ROCK

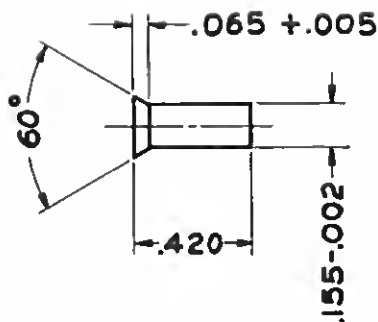
11 5-10-48

DRG. PERTAINS TO

C5564185

30 BMG
M17A1 (WC)

C5564222

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A5 (FXD)
M19A6

RIVET
STEEL FSX1315
FINISH 125/

5020514

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm \frac{\quad}{\quad}$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

J.J.V.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.E. Hgt.

O.D.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS A20514

SCALE $\frac{2}{1}$

A

5020514

A5024602

JUNE 1, 1931

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

13 5-10-48

DRG. PERTAINS TO

ORDNANCE DIVISIONAL
STANDARDINSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\frac{1}{16}$ ANGULAR 2°

DRAFTSMAN

TRACER

L'DG DRAFTSMAN

E.L.F.

E.B.

CHECKED

O.O.

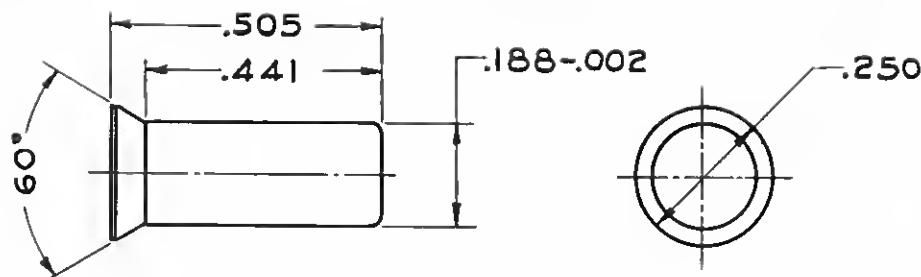
CHIEF DRAFTSMAN

SUBMITTED:

*A.H. Roe*APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter A. Korman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

RIVET, MOUNT ADAPTERSTEEL FS1035FINISH $\frac{1}{25}$ V

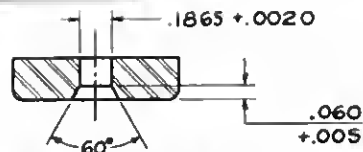
5024602

WAS A24602

SCALE $\frac{4}{1}$

A 5024602

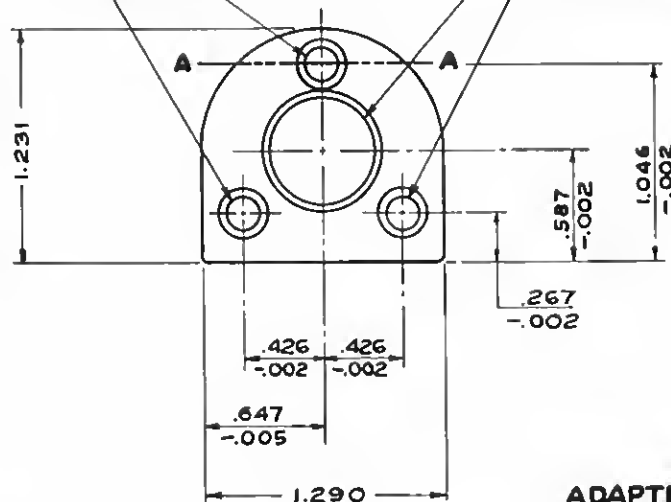
HEAT TREATMENT AND FINAL FINISH



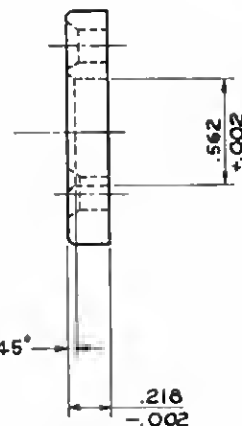
SECTION A-A

REAM AT ASSEMBLY
WITH R. & L. SIDE PLATES

REAM AFTER TRUNNION
BLOCK IS ASSEMBLED



.035 x 45°



ADAPTER, MOUNT
STEEL WD 1035
FINISH 125/

6017462

SCALE $\frac{2}{1}$

WAS B 17462

B 6017462

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JUNE 1, 1931

REVISIONS

15 5-10-48

DRG. PERTAINS TO

C5564185 .30 BMG
M17A1 (WC)
C5564186 .30 BMG
M17A1 (WC)
C5594516 .30 BMG
M19A6
E5590722 .30 BMG
M19A4 (FXD)
E5564222 .30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6
C5564224 .30 BMG
M19A4 (FXD)
M19A4 (FLEX)

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: ± .005
FRACTIONAL: -
ANGULAR: -

DESIGNED BY: E.R.F. O.K.
CHECKED BY: J.W.H. O.K.
DATE: 5/10/48

SUBMITTED:

A.H. ROE

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...

SEC. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

B6017462

HEAT TREATMENT AND FINAL FINISH

CARBON CASE .010 TO .015 DEEP. ANNEAL
ONE HALF INCH OF SMALL END.

PHYSICAL PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A78-83
SCL.	

JUNE 1, 1931

REVISIONS

11	5-10-48		

DRG. PERTAINS TO

C5564185	10 BMG
C5564222	M17A1 (WC)
	.30 BMG
	M19A4 (FXD)
	M19A4 (FLEX)
	M19A5 (FXD)
	M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 2°

DESIGNED	TRACED	C'DG. DRAFTSMAN
C.S.S.	O.K.	
CHECKED		CHIEF DRAFTSMAN
L.S.		

SUBMITTED:

A.H. Roe

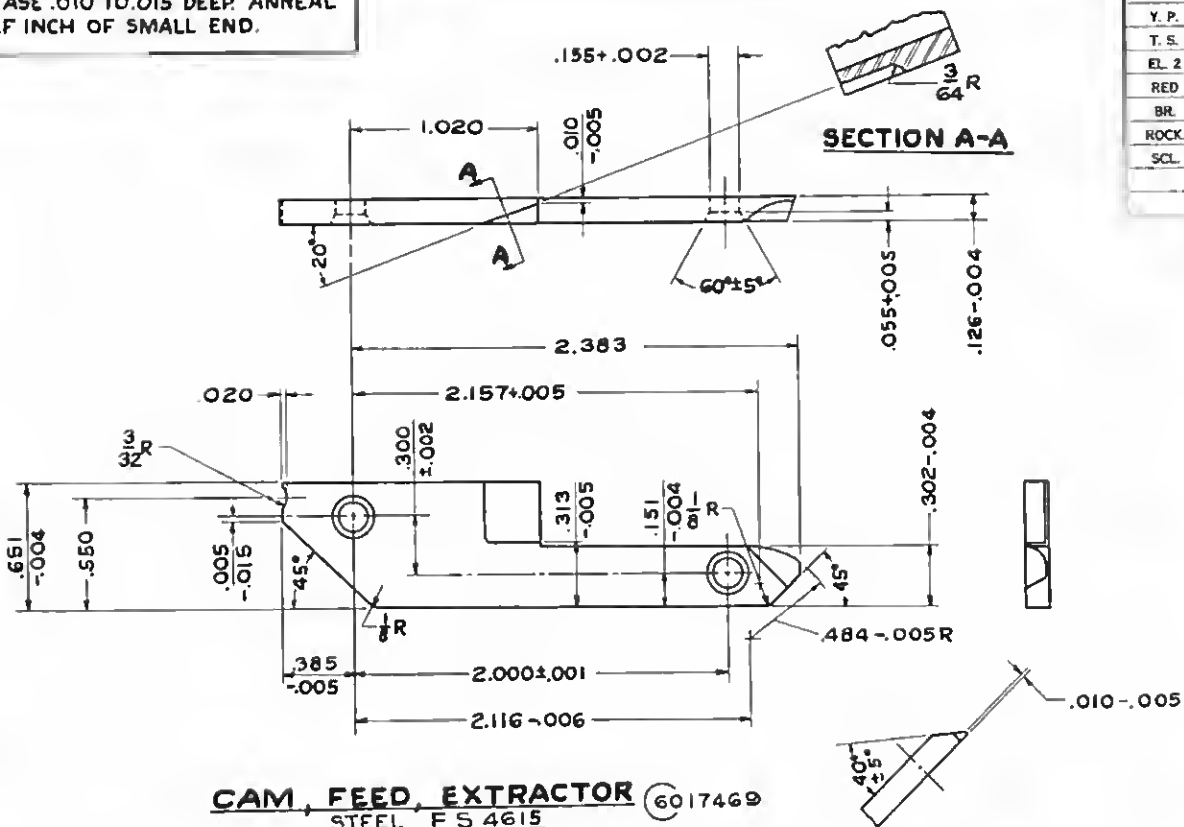
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



CAM FEED EXTRACTOR (6017469)
STEEL F S 4615
FINISH 125/

WAS B17469

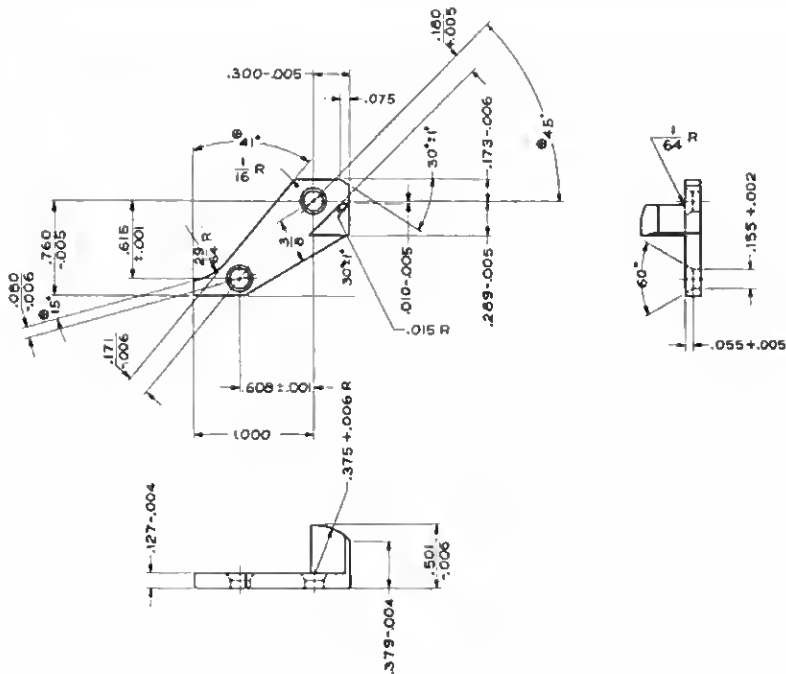
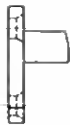
SCALE 2/1

B 6017469

B6017469

HEAT TREATMENT AND FINAL FINISH

CARBON CASE .010 TO .015 DEEP.
ANNEAL $\frac{1}{2}$ INCH OF SMALL END.



CAM EXTRACTOR
STEEL FS4615
FINISH 125

5508452

● PERMISSIBLE ANGLE TOLERANCES NOT SPECIFIED, MUST BE WITHIN LIMITS PRESCRIBED BY LOCATING DIMENSIONS.

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y P		15	5-10-48
T. S.			
EL. 2			
RED			
BR.			
NOGA	A78-83		
SCL			

DRG. PERTAINS TO

C5564182 30 BMS
M19A1 (W/L)
C5564223 30 BMS
M19A4 (FXD)
30 BMS
M19A4 (FLEX)
30 BMS
M19A5 (FXD)
30 BMS
M19A6

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: $\pm .008$
FRACTIONAL: $\pm 1/64$
ANGULAR: $\pm 5'$

DESIGNED C.S.	FORGED L.R.	TESTED L.S.
SUBMITTED		

APPROVED BY
AMRoe

WAS C6452

DO NOT INSCRIBE PART NO.

SCALE $\frac{2}{1}$

C5508452

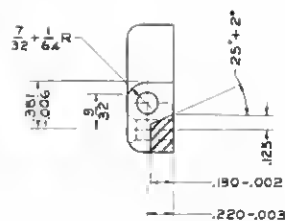
APPROVED BY CHIEF OF DIVISION
W. H. H. H.
2000 2000 2000 2000
ORDINANCE DEPT., U. S. A.
MADE AT BUREAU OF ARMS

C5508452

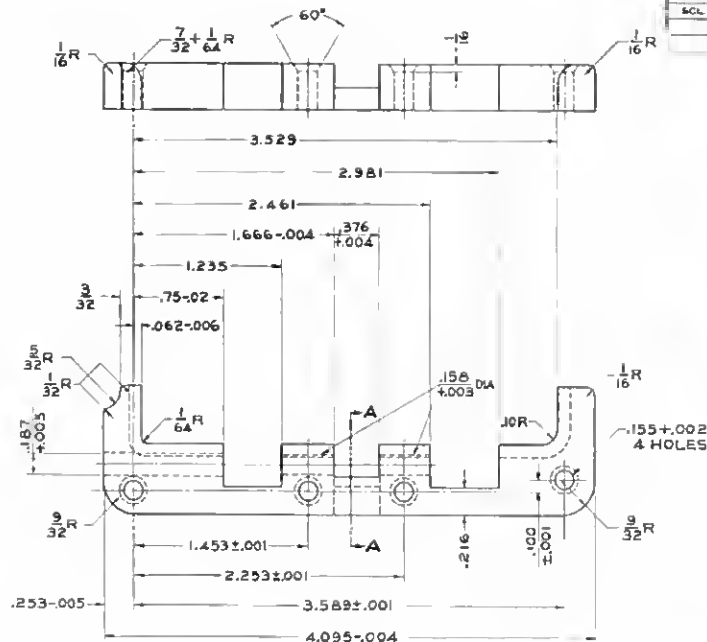
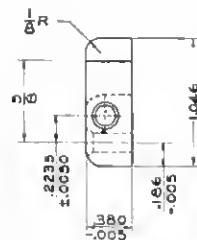
PHYSICAL PROPERTIES		FEBRUARY 1, 1938	
		REVISIONS	
Y. P.		13	5-10-48
T. S.			
EL. &			
RED.			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

C5564185	30 B.M.G.
C5564222	M17A (WC)
	30 B.M.G.
	M19A3 (FXD)
	30 B.M.G.
	M19A4 (FLX)
	30 B.M.G.
	M19A3 (FXD)
	30 B.M.G.
	M19A6



SECTION A-A



BRACKET, BELT HOLDING PAWL
STEEL F5X1020
FINISH 125/

C5564132

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± .003
FRACTIONAL ± 1/64
ANGULAR ± 1°

J. U. E. B.

SUBMITTED

WAS 64132

DO NOT INSCRIBE PART NO.

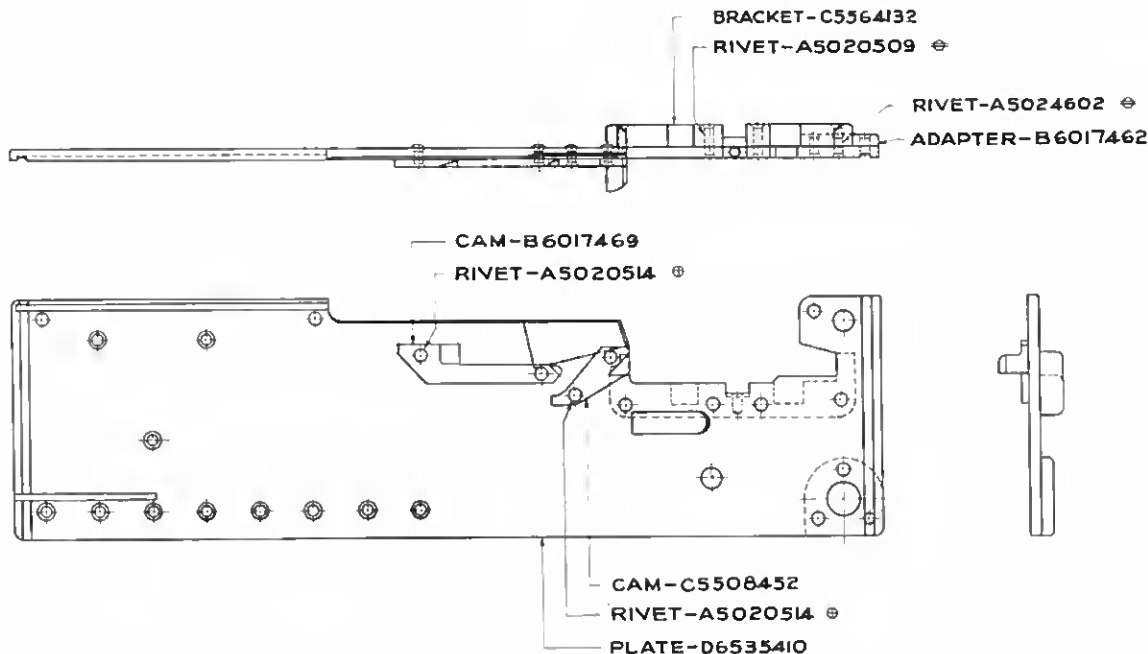
SCALE 2

C5564132

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE
Walter C. Anderson
ORD. DEPT. U. S. A.
MADE BY BUSH INLAND ARMORY

C5564132

HEAT TREATMENT AND FINAL FINISH



PLATE, SIDE, L.H. ASSEMBLY

5564222

NOTE:

- ⊕ GRIND FLUSH INSIDE
- ⊗ GRIND FLUSH INSIDE AND OUTSIDE

PHYSICAL PROPERTIES		MARCH 10, 1939	
		REVISIONS	
Y P		10	5-10-48
Y S			
EL 2			
RED			
BR			
ROCK			
SCL			

DRG PERTAINS TO

06535358 30 BME
 06540989 30 BMG
 07114037 30 BMG
 M1946

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± —
 FRACTIONAL ± —
 ANGULAR ± —

DESIGNED BY: R.S.B. E.B. 100% INSPECTED
 CHECKED BY: [Signature] 100% INSPECTED

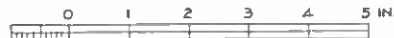
SUBMITTED

[Signature]

APPROVED BY: [Signature] 100% INSPECTED
 OF ORDNANCE

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL



WAS C64222

5564222

C5564222

PHYSICAL PROPERTIES	
YR.	
T.S.	
CL-2	
RED.	
HT.T.	
BR.	
SCL.	
C.C.	

0655410

[illegible]

DO NOT INSCRIBE PART NO.

PHYSICAL PROPERTIES		MARCH 10, 1935
		REVISIONS
V P		6 5-10-48
T S		
EL 2		
RED		
BR		
ROCK		
SCL		

DRG. PERTAINING TO

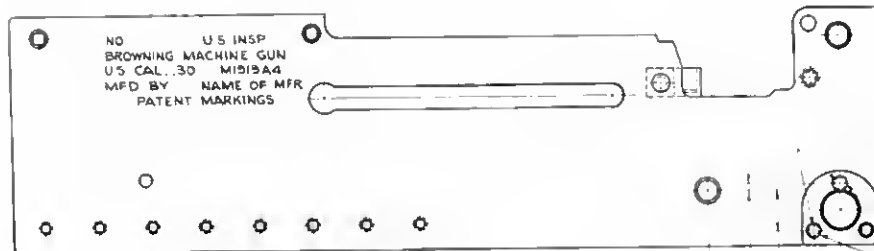
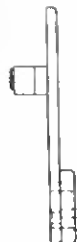
04335358 30 848
M19A4 (S-1) (FILE)

STOP-A5024603
STDP-B6131258

PLATE-D6635411



RIVET-A5020589
ADAPTER-B6017462



1865 + 0020

RIVET-A5024602

105
670
1775
2200

PLATE, SIDE, R.H., ASSEMBLY

5564224

NOTE: GRIND ALL RIVETS FLUSH
OUTSIDE AND INSIDE.

INSCRIBE PART NO
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .001
FRACTIONAL: 1/16
ANGULAR: 1/2

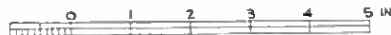
CFJ
SUBMITTED

APPROVED BY ORDER OF THE CHIEF
OF DIVISION

WAS CG4224

ORDNANCE DEPT., U. S. A.

MADE AT RUSS INLAND ARMS



WAS CG4224

5564224

C5564224

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A3020589
JUNE 1, 1931

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

8 5-10-48

DRG. PERTAINS TO

C5564186

.30 BMG
M17A1 (WC)

C5564224

.30 BMG 19A4
(FXD) & (FLEX)

C5590722

.30 BMG
M19A5 (FXD)

C5594516

.30 BMG
M19A6INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

M.E.B.

TRACER

L.R.E.

L'D'G DRAFTSMAN

CHECKER

L.S.C.

CHIEF DRAFTSMAN

SUBMITTED:

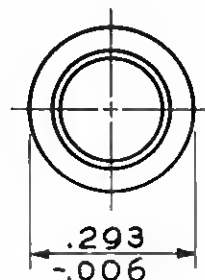
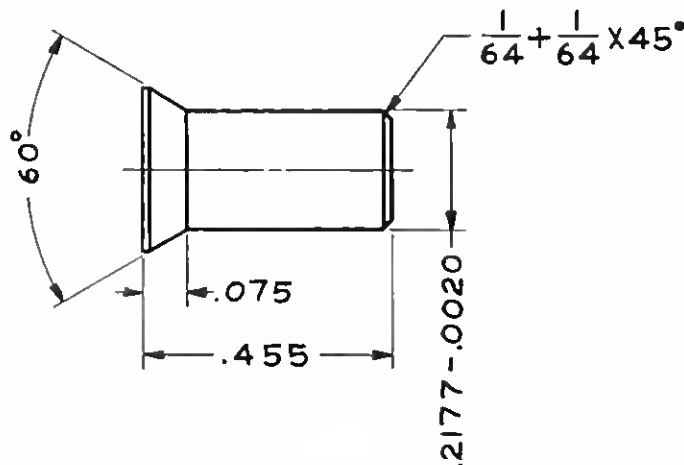
A. H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Ackerman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

RIVET, REAR CARTRIDGE STOPSTEEL F51035FINISH 125

5020589

WAS A20589

SCALE $\frac{4}{1}$

A

5020589

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 1, 1931

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

13 5-10-48

DRG. PERTAINS TO
ORDNANCE DIVISIONAL
STANDARD

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\frac{-}{+}$
ANGULAR $- 2^{\circ}$

DRAFTSMAN

E.L.F.

TRACER

E.B.

L'O'G DRAFTSMAN

E.L.F.

E.B.

CHIEF DRAFTSMAN

SUBMITTED:

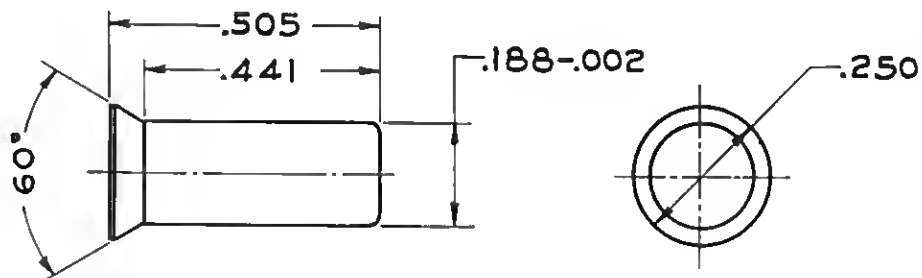
A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. Korman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



RIVET, MOUNT ADAPTER

STEEL FS1035

FINISH $\frac{125}{V}$

5024602

WAS A24602

SCALE $\frac{1}{4}$

A 5024602

JUNE 1, 1931

REVISIONS

12 5-10-48

DRG. PERTAINS TO

C5584186

.30 BMG
M17A1 (WC)

C5584224

.30 BMG 19A4
(FXD) & (FLX)

C5590722

.30 BMG
M19A3 (FXD)

C5594516

.30 BMG
M19A6INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{64}$ ANGULAR $\pm 5^\circ$

DRAFTSMAN

W.C.Q.

TRACER

E.R.Q.

L'D'G DRAFTSMAN

CHECKER

W.C.Q.

CHIEF DRAFTSMAN

O.O.

SUBMITTED:

A.H. ROE

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

Y. P.

RED.

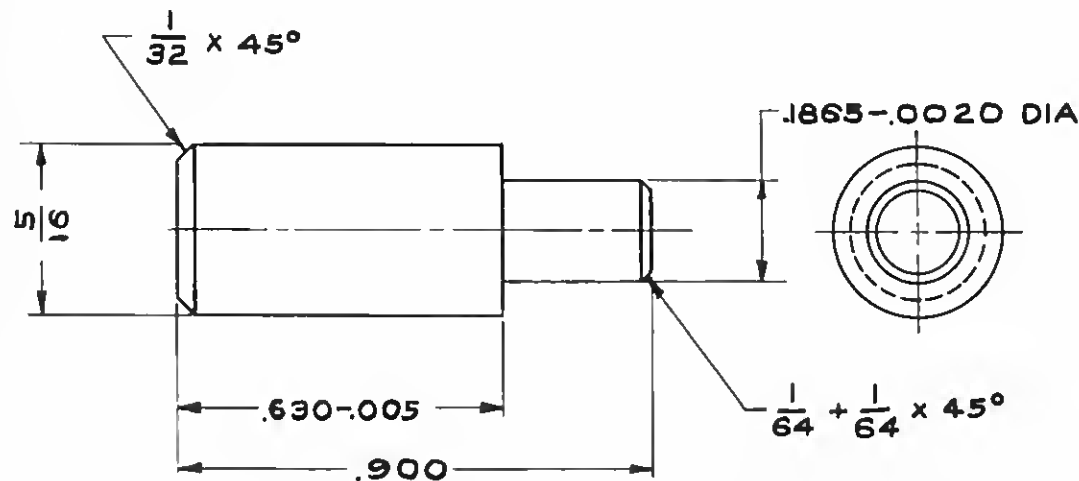
SCL.

T. S.

BR.

EL. 2

ROCK

STOP CARTRIDGE, FRONTSTEEL FSX1335

FINISH 125/



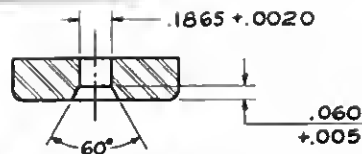
5024603

WAS A24603

SCALE $\frac{4}{1}$

A 5024603

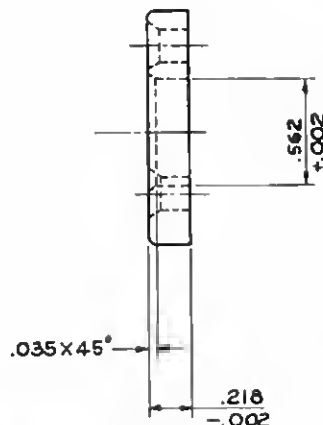
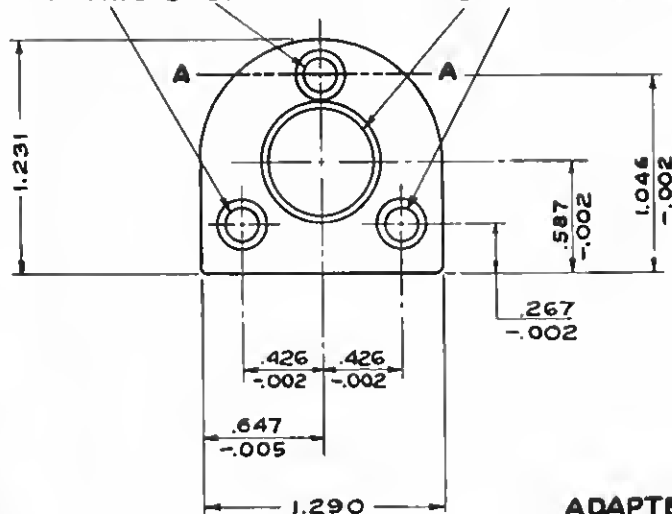
HEAT TREATMENT AND FINAL FINISH



SECTION A-A

REAM AT ASSEMBLY
WITH R.+L. SIDE PLATES

REAM AFTER TRUNNION
BLOCK IS ASSEMBLED



ADAPTER, MOUNT
STEEL WD 1035
FINISH 125/

6017462

SCALE $\frac{2}{1}$

WAS B17462

B 6017462

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JUNE 1, 1931

REVISIONS

15	5-10-48	

DRG. PERTAINS TO

C5564185	3" BMG M17A1 (WC)
C5564186	.30 BMG M17A1 (WC)
C5594516	.30 BMG M19A6
C5590722	.30 BMG M19A5 (FXD)
C5564222	.30 BMG M19A4 (FXD) M19A4 (FLEX) M19A4 (FLEX)
C5564224	.30 BMG M19A4 (FXD) M19A4 (FLEX)

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: -
ANGULAR: -

DESIGNED E. J. J.	TRACED O. K.	CHECKED G. A.	CHIEF DRAFTER
----------------------	-----------------	------------------	---------------

SUBMITTED:

A. H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

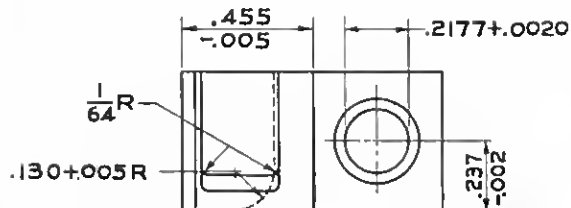
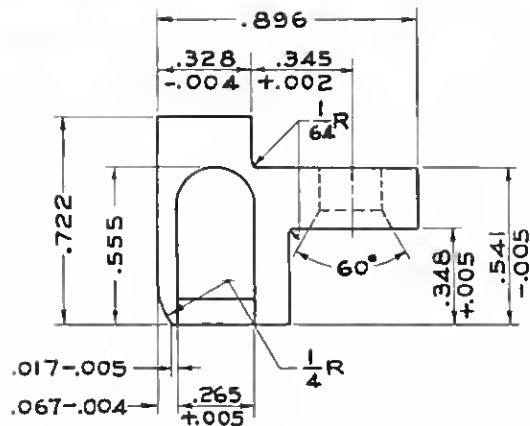
W. A. G.

ORDNANCE DEPT., U. S. A.

B6017462

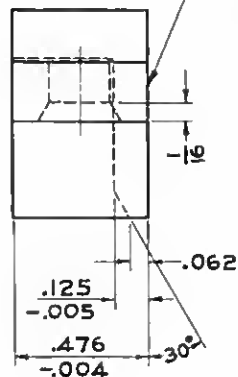
HEAT TREATMENT AND FINAL FINISH

HEAT TREAT



INSCRIBE PART NO.

1/16 HIGH



STOP, CARTRIDGE, REAR

STEEL FS3115

FINISH 125

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL. 2

RED

BR.

ROCK.

SCL.

C34-40

JUNE 1, 1931

REVISIONS

10 5-10-40

DRG. PERTAINS TO

C5564186

C5564224

C5594516

C5590722

M17A1(WC)
 .30 BMG
 M19A4(FXD)
 M19A4(FLEX)
 .50 BMG
 M19A6
 .30 BMG
 M19A5(FXD)

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: $\pm .005$
 FRACTIONAL: $\pm 1/64$
 ANGULAR: $\pm 1^\circ$

DEVELOPER	TECHNICAL	CHIEF DRAFTSMAN
F.C.L.	E.B.	
50%	50%	50%
CHIEF DRAFTSMAN		

SUBMITTED:

A.H. ROE

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE:

Walter A. Korman
 ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

WAS B131258

SCALE 3/4

B

6131258

B6131258

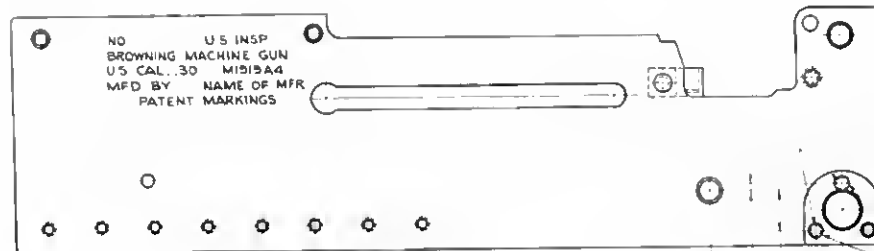
PHYSICAL PROPERTIES		MARCH 10, 1935	
		REVISIONS	
V P		6	5-10-48
T S			
EL J			
RED			
BR			
ROCK			
SCL			

DRG PERTAINS TO

 04335358 30 848
 MISAS (S) (FLY)

 STOP-A5024603
 STDP-B6131258

PLATE-D6635411


 RIVET-A5020589
 ADAPTER-B6017462


1865 + 0020

RIVET-A5024602

 .105
 .670
 1
 1775
 2200

PLATE, SIDE, R.H., ASSEMBLY

5564224

NOTE: GRIND ALL RIVETS FLUSH
OUTSIDE AND INSIDE.INSCRIBE PART NO
00 NOT
 TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: .001
 FRACTIONAL: 1/16
 ANGULAR: 1/2

CFJ

SUBMITTED:

 APPROVED BY ORDER OF THE CHIEF
 OF DIVISION

 APPROVED BY ORDER OF THE CHIEF
 OF DIVISION

 APPROVED BY ORDER OF THE CHIEF
 OF DIVISION

 APPROVED BY ORDER OF THE CHIEF
 OF DIVISION

 APPROVED BY ORDER OF THE CHIEF
 OF DIVISION

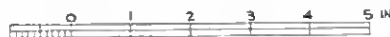
 APPROVED BY ORDER OF THE CHIEF
 OF DIVISION

WAS CG4224

05564224

ORDNANCE DEPT., U. S. A.

MADE AT RUSS INLAND ARMS



05564224

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL. 2

RED

BR.

ROCK.

SCL.

JUNE 1, 1931

REVISIONS

14 5-10-48

DRG. PERTAINS TO

51-114-1

30 BMG
M19A5 (FXD)

51-125-1

30 BMG
M19A5

51-83-1

30 BMG
M19A4 (FXD)

51-84-1

30 BMG
M19A4 (FLY)

51-10-1

30 BMG
M17A1 (WC)INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ±
FRACTIONAL ±
ANGULAR ±

DRAWN	SC.F	TRACES	AVC.	1/2" & SMALLER
CHIEF	CHIEF	CHIEF	CHIEF	CHIEF
<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Ackerman*

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

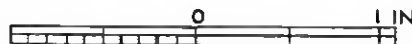
PIN-A5020490

PLUNGER-B6017508

RIVET OVER & FILE FLUSH

PLUNGER, BARREL, ASSEMBLYFINISH $\sqrt{\text{V}}$ TO BE $\sqrt{\text{V}}$ 125/

(6131251)



WAS B131251

B 6131251

B6131251

A 5020490

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

APRIL 4, 1927

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

10 5-10-48

DRG. PERTAINS TO

B6131251

50 BING
 M17A1 (WC)
 M19A4 (FXD)
 M19A4 (FLEX)
 M19A3 (FXD)
 M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$
 FRACTIONAL $\pm 1/64$
 ANGULAR $\pm 5^\circ$

DRAFTSMAN

E.L.J.

TRACER

A.V.C.

L.D.G. DRAFTSMAN

CHECKER

L.S.C.

O.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

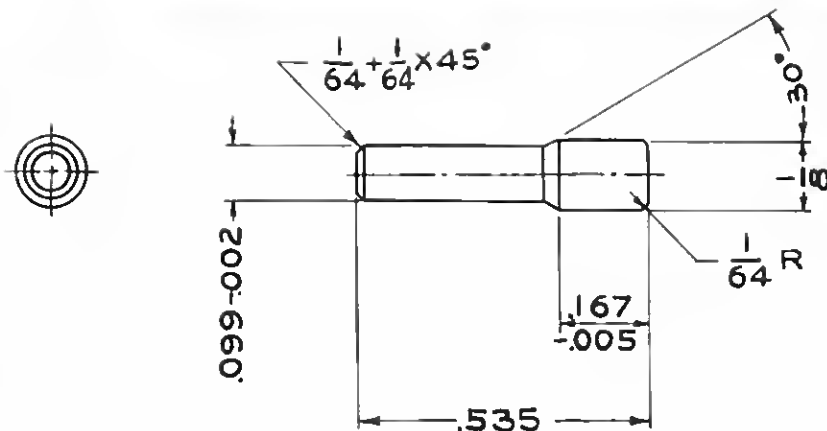
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE:

Walter

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



PIN, GUIDE, BARREL PLUNGER

STEEL FS1095

FINISH 125/

5020490

WAS A20490

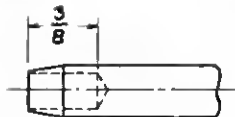
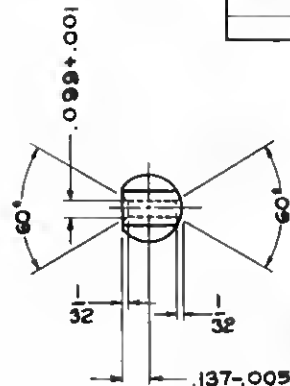
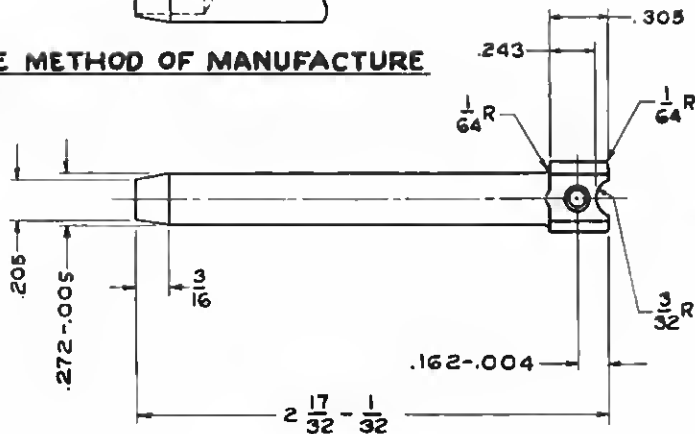
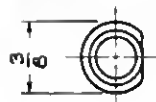
SCALE $\frac{4}{1}$

A 5020490

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT

.187+.005

**ALTERNATIVE METHOD OF MANUFACTURE**

PLUNGER, BARREL (6017508)
STEEL FS 4140
 FINISH 125/

PHYSICAL PROPERTIES

Y. P.
 T. S.
 EL. 2
 RED
 BR.
 ROCK. C 33-39
 SCL.

APRIL 4, 1927

REVISIONS

13	5-10-48	

DRG. PERTAINS TO

60131251 .50 BMG
 M17A1
 M19A4 (FXD)
 M19A4 (FLEX)
 M19A5 (FXD)
 M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: .005
 FRACTIONAL: 1/64
 ANGULAR: 5°

DESIGNED W.C.Q.	HECKED O.K.	1/8 INCHES CHIEF DRAFTSMAN
CHIEF E.S.	CHIEF E.A.	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe
 CHIEF, U.S.A.

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE-

Walter A. ...
 CHIEF, U.S.A.

ORDNANCE DEPT., U. S. A.

WAS B 17508

SCALE $\frac{2}{1}$

B 6017508

B6017508

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

PHYSICAL
PROPERTIES

Y. P.

T. S.

EL. 2

RED

BR.

ROCK.

SCL.

JUNE 1, 1931

REVISIONS

14 5-10-48

DRG. PERTAINS TO

51-114-1

30 BMG
M19A5 (FXD)

51-125-1

30 BMG
M19A5

51-83-1

30 BMG
M19A4 (FXD)

51-84-1

30 BMG
M19A4 (FLY)

51-10-1

30 BMG
M17A1 (WC)

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ±
FRACTIONAL ±
ANGULAR ±DRAFTSMAN
S.C.F.CHECKER
A.V.C.

1/4" & DRAFTSMAN

CHIEF DRAFTSMAN

SUBMITTED:

A.H. ROE

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

PIN-A5020490

PLUNGER-B6017508

RIVET OVER & FILE FLUSH

PLUNGER, BARREL, ASSEMBLYFINISH $\sqrt{\text{V}}$ TO BE $\sqrt{\text{V}}$ 125/

(6131251)



WAS B131251

B 6131251

B6131251

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

MAY 16, 1946

REVISIONS

2 5-10-48

DRG. PERTAINS TO

27132923

M19A4 (X.D)
M19A4 (LEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNED <i>AM</i>	TRACED <i>O.K.</i>	CHECKED <i>AM</i>
ENGINEER	CHIEF DESIGNER	

SUBMITTED:

A.H. Roe

ORD. DEPT. - U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT. - U. S. A.

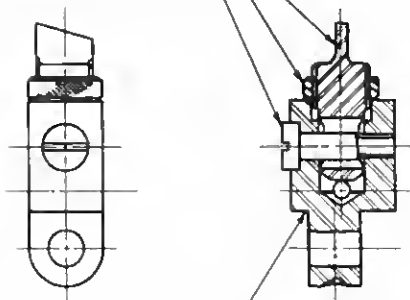
ORDNANCE DEPT., U. S. A.

SCREW-A7162633

NUT-A7162631

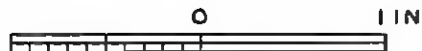
BLADE - A7162630

POST-A7162632



POST, FRONT SIGHT ASSEMBLY (7162616

SUPERSEDES B7162616 WO/C 5-10-48



B 7162616

B7162616

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A7162630

MAY 16, 1946

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

1 5-10-48

DRG. PERTAINS TO

B7162616

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 3^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

CHECKED

O.K.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

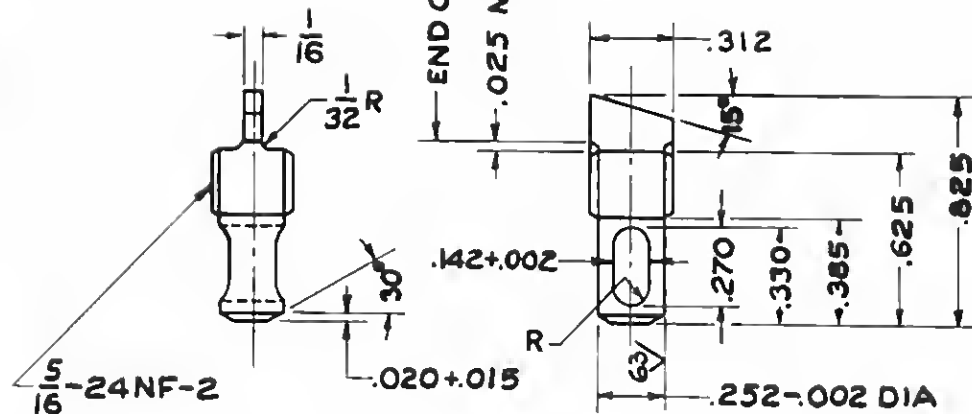
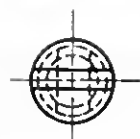
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

END OF THREAD
.025 MAX.**BLADE, FRONT SIGHT****STEEL FSX 1020**

(7162630)

FINISH $\frac{125}{V}$, OTHER SURFACES, AS SPECIFIED

SUPERSEDES A7162630 WO/C 5-10-48

SCALE $\frac{2}{1}$

A

7162630

A7162631

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MAY 16, 1946

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

E. L. 2

ROCK

REVISIONS

1 5-10-48

DRG. PERTAINS TO

B7162616

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19AG

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL + .005

FRACTIONAL + -

ANGULAR + 3°

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

KIM

O.K.

CHECKER

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

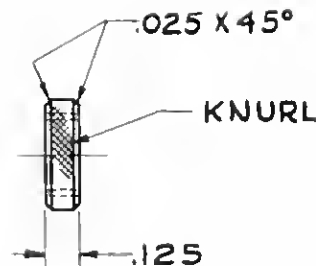
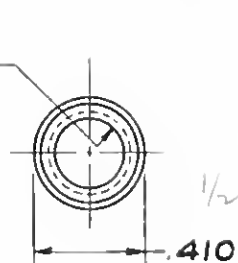
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORONANCE

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

 $\frac{5}{16}$ - 24 NF - 2

KNURL

NUT, ADJUSTING, FRONT SIGHT BLADESTEEL FS 1020FINISH 125

⑦162631

SUPERSEDES A7162631 WO/C 5-10-48

SCALE $\frac{2}{1}$

A7162631

A7162632

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MAY 16, 1946

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

1 5-10-48

DRG. PERTAINS TO

B 7162616

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 3^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

CHECKER

CHIEF DRAFTSMAN

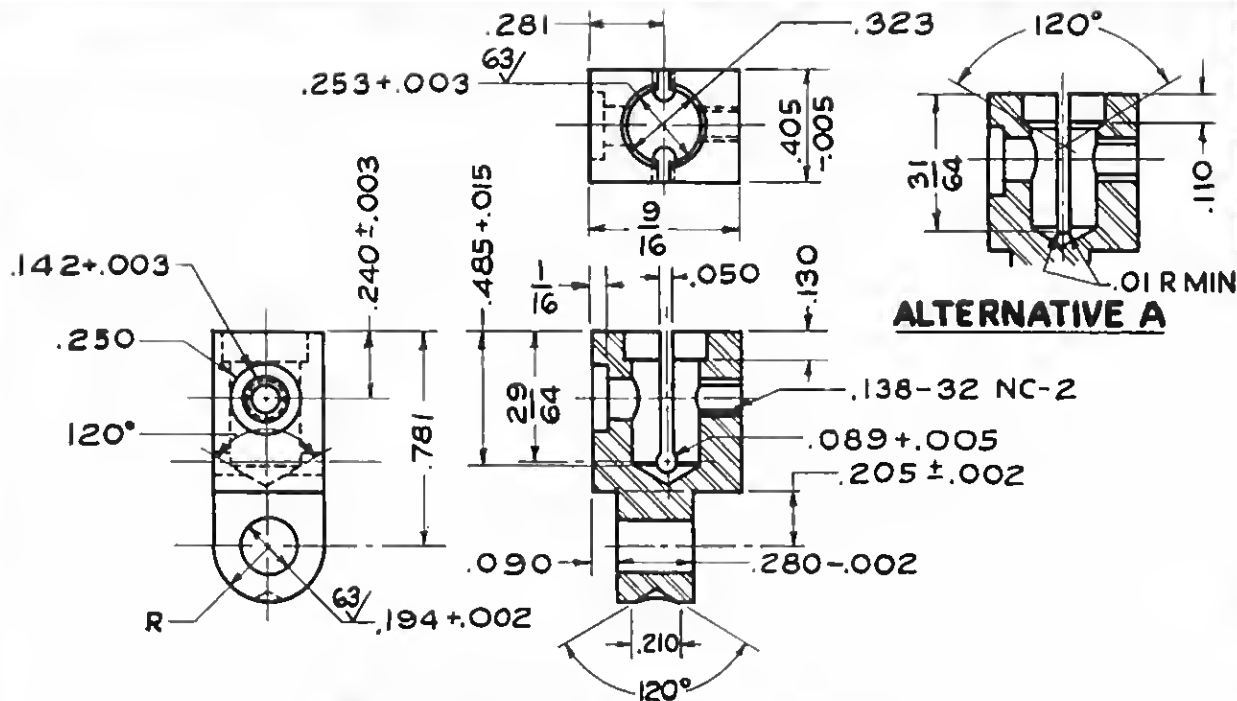
SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

**POST, FRONT SIGHT****STEEL FSX 1020**

7162632

FINISH $125/$ OTHER SURFACES, AS SPECIFIED

SUPERSEDES A7162632 WO/C 5-10-48

SCALE $\frac{2}{1}$

A

7162632

A7162633

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MAY 16, 1946

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

E. L. 2

ROCK

REVISIONS

1 5-10-48

DRG. PERTAINS TO

B7162616

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR ± 0

D. MAN

TRACER

L'DG DRAFTSMAN

CHECKER

CHIEF DRAFTSMAN

SUBMITTED:

A.H. ROE

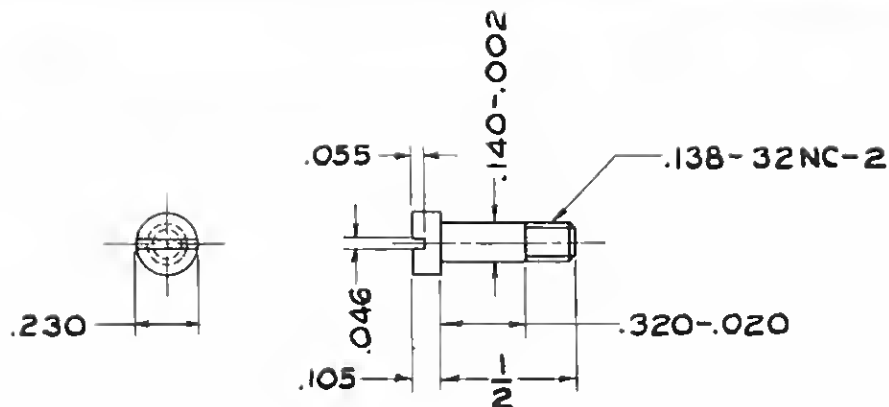
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



SCREW, CLAMPING, FRONT SIGHT BLADE (7162633)

STEEL FSX1315

FINISH 125/

SUPERSEDES A7162633 WO/C 5-10-48

SCALE $\frac{2}{1}$

A7162633

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
WCL
SCL

FEBRUARY 25, 1947

REVISIONS

1 5-10-48

DRG. PERTAINS TO

51-83-1 M19A1 (FMD)
30 BMG
51-84-1 M19A4 (FLEX)
30 BMG
51-125-1 M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNER	TECHER	C. O. DESIGNER
D. E. R.	O. K.	
CHECKER	C. O.	C. O. DESIGNER
R. S.		

SUBMITTED:

A. H. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter R. ...
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

★POST, FRONT SIGHT, ASSEMBLY - B 7162616
PLUNGER-A5156881

SCREW-A5156884
SPRING-A5156882
⊕ SCREW-A5156883

STAKE
WASHER-A7110440

STAKE

BODY-B6144237

SCREW-A5013258
SCREW-A5013249

SIGHT, BRACKET, GROUP ASSEMBLY (7)32923

⊕ NOT REQ'D WHEN
ALTERNATIVE METHOD
OF MANUFACTURE OF
B6144237 IS USED.

SUPERSEDES B7132923 W/C 5-10-48



★ FINDING DIAGRAM

B 7132923

B7132923

A5013249

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

JUNE 1, 1931

REVISIONS

HEAT TREAT
TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

C. C.

.003 TO .005
DEEP

EL 2

ROCK

12 5-10-48

DRG. PERTAINS TO

B 144235

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19AG

B 7132923

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL \pm —ANGULAR $\pm 5^\circ$

DRAFTSMAN

TRACER

LD'S DRAFTSMAN

CHECKED

O.K.

CHIEF DRAFTSMAN

C. H. C. W. R.

O. O.

SUBMITTED:

A. H. Roe

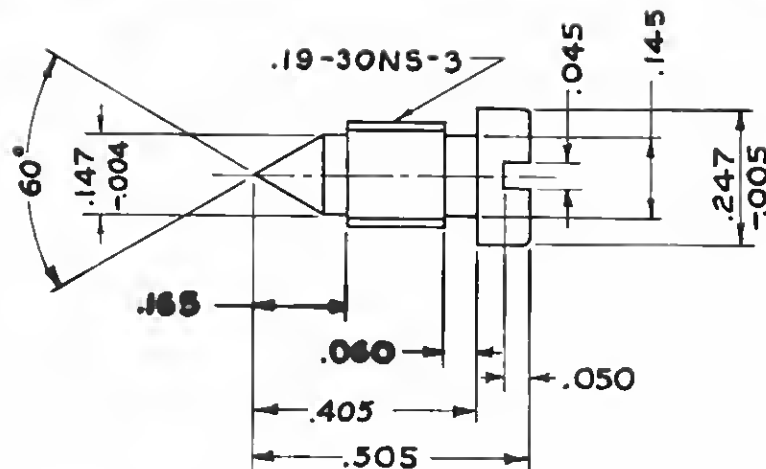
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



SCREW, LOCKING, FRONT SIGHT BRACKET (5013249)

STEEL FS X1315

FINISH 125/

WAS A13249

SCALE $\frac{4}{1}$

A 5013249

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

A5013258

JUNE 1, 1931

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

105-10-48

DRG. PERTAINS TO

B 144235

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

B7132923

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL \pm —ANGULAR $\pm 5^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

E. J. J.

O.K.

CHECKED

O.K.

CHIEF DRAFTSMAN

E. J. J.

SUBMITTED:

F. H. ROE

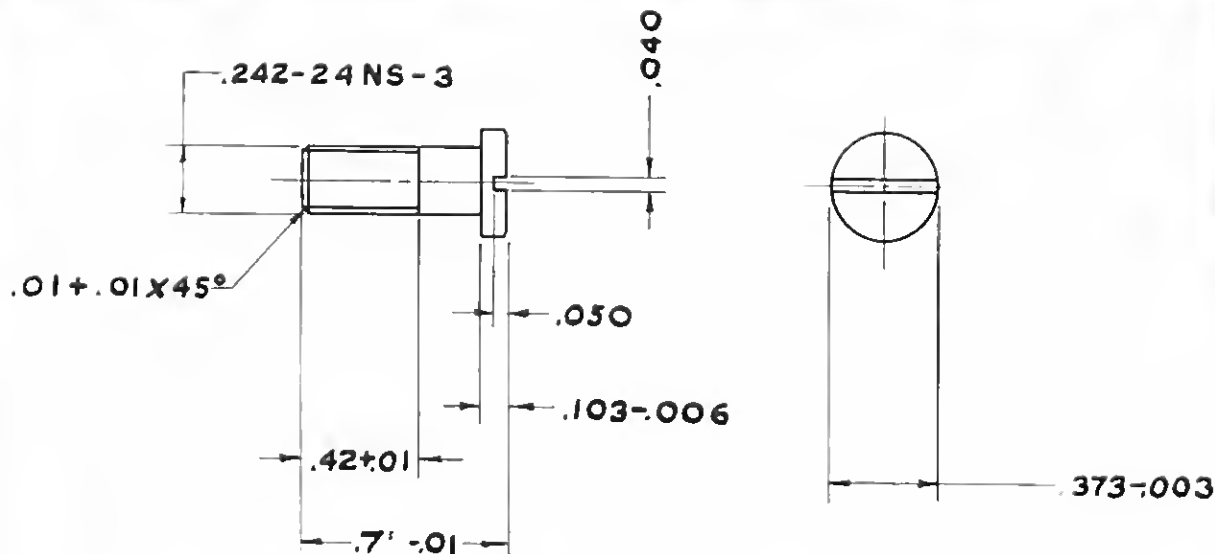
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



SCREW, FRONT SIGHT BRACKET (5013258)

STEEL FS X 1315

FINISH 125

WAS A 13258

SCALE $\frac{2}{1}$

A 5013258

A 5156881

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

6 5-10-48

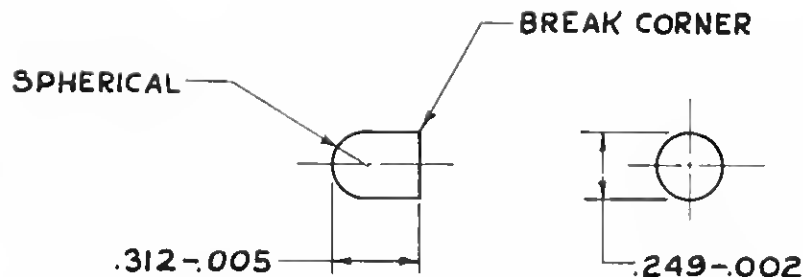
NOTE: A .249-.002 DIA HARDENED
AND GROUND STEEL BALL MAY
BE USED AS AN ALTERNATIVE
METHOD OF MANUFACTURE.

DRG. PERTAINS TO

B 144235

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

B7132923



INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL \pm —FRACTIONAL \pm —ANGULAR \pm —

DRAFTSMAN

TRACER

L'D'S DRAFTSMAN

H.O.C.

O.K.

CHECKER

CHIEF DRAFTSMAN

L.S.S.

O.O.

PLUNGER, FRONT SIGHTSTEEL FSX 1020

FINISH 63/

(5) 56881

WAS A 156881

SCALE $\frac{2}{1}$

A 5156881

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

5156882

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

DRAW AT 450°F
TYPE I FINISH, CLASS OSC
BAKE ONE HOUR AT 300-350°F

Y. P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.	<input checked="" type="checkbox"/>
T. S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>		
EL. 2	<input checked="" type="checkbox"/>	ROCK	<input checked="" type="checkbox"/>		

REVISIONS

8 5-10-48

DRG. PERTAINS TO

B 144235

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19AG

B7132923

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL ± —

FRACTIONAL ± —

ANGULAR ± —

DRAFTSMAN

W.L.M.

TRACER

E.B.

L'D'G DRAFTSMAN

CHECKED

C. O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Asherman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

DIAMETER OF WIRE — .034
TOTAL NUMBER OF COILS — 15
OUTSIDE DIAMETER FREE — .224 ± .004
MAX OUTSIDE DIA AT MIN OPERATING HEIGHT — .230
FREE LENGTH — 1.00 ± .03
TYPE OF ENDS — SQ. AND GROUND
WOUND — R. H.
MEAN ASSEMBLED HEIGHT — .593
MIN LOAD AT MEAN ASSEMBLED HEIGHT — 9.75 LB
MINIMUM OPERATING HEIGHT — .527
MIN LOAD AT MINIMUM OPERATING HEIGHT — 11.33 LB
LB PER INCH OF SPRING DEFLECTION — 24
SPRING FUNCTIONS IN HOLE — .250
CALCULATED MAXIMUM SOLID HEIGHT — .510

CAUTION: DO NOT COMPRESS SOLID.

SPRING, FRONT SIGHTSPRING STEEL WIRE

(WD1085 SPECIAL-CLASS A)

5156882

WAS A156882

A 5156882

A 5156883

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

REVISIONS

8 5-10-48

DRG. PERTAINS TO

B 144235

.30 BMG
M 19A4 (FXD)
M 19A4 (FLEX)
M 19AG

B7132923

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL \pm —ANGULAR $\pm 5^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

H.O.C.

O.K.

CHECKER

CHIEF DRAFTSMAN

L.S.C.

O.O.

SUBMITTED:

A.H. Roe

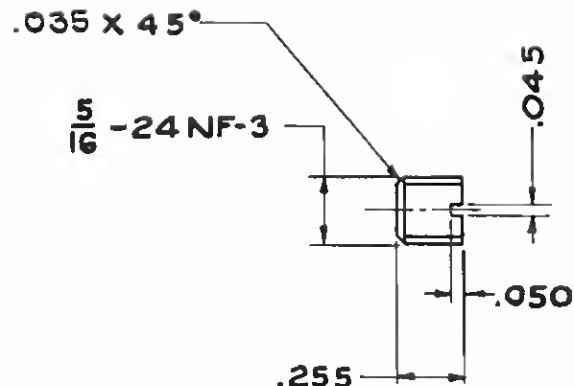
DRD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

DRD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SCREW, RETAINING, FRONT SIGHTSTEEL FSX1315

FINISH 125/

(5156883

WAS A156883

SCALE $\frac{2}{1}$

A

5156883

A5156884

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

7 5-10-48

DRG. PERTAINS TO

B 144235

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19AG

B7132923

INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm -$
ANGULAR $\pm 5^\circ$

DRAFTSMAN

TRACER

L'D'G DRAFTSMAN

H.D.C.

O.K.

CHECKED

CHIEF DRAFTSMAN

LSC

O.O.

SUBMITTED:

A.H. Roe

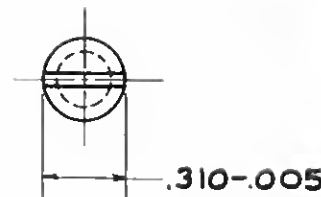
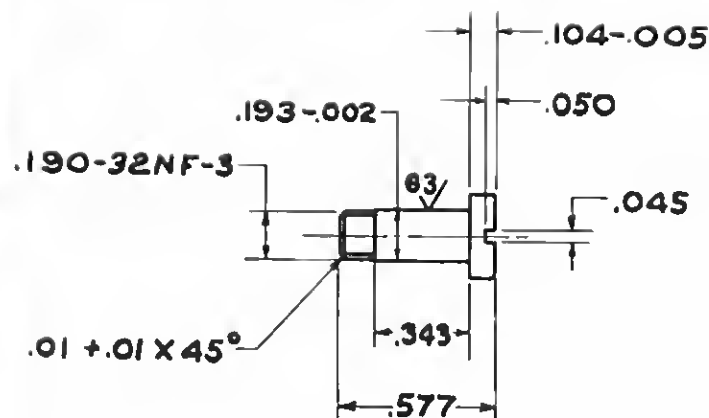
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SCREW BEARING, FRONT SIGHTSTEEL FS X 1315FINISH 125 OTHER SURFACES, AS SPECIFIED

WAS A 156884

SCALE $\frac{2}{1}$

A

5156884

A7110440

JANUARY 31, 1944

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

3 5-10-48

DRG. PERTAINS TO

B 144235

B7132923

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6INSCRIBE PART NO.
DO NOTTOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL \pm —
FRACTIONAL \pm —
ANGULAR \pm —

DRAFTSMAN

H. G. 26

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKED

H.W. J.

C.O.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

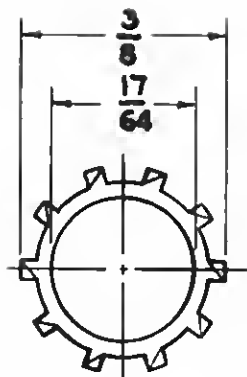
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WASHER, LOCK.022 STEEL - COMMERCIAL

7110440

SHAKEPROOF EXTERNAL TOOTH LOCK WASHER NO. 1114-05 OR EQUAL

SUPERSEDES A7110440 WO/C 5-10-48

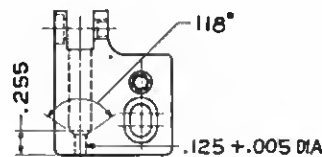
SCALE $\frac{4}{1}$

A

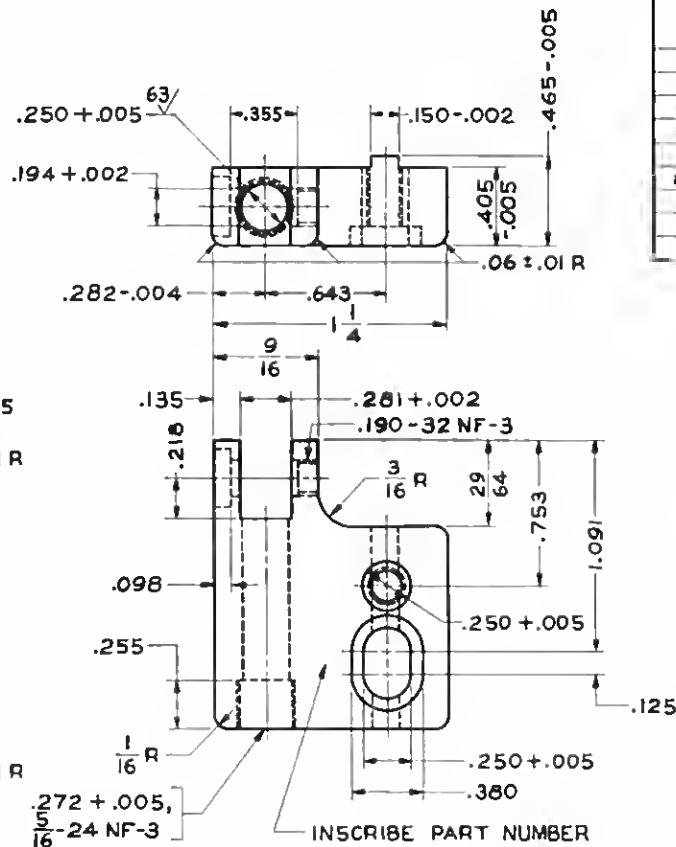
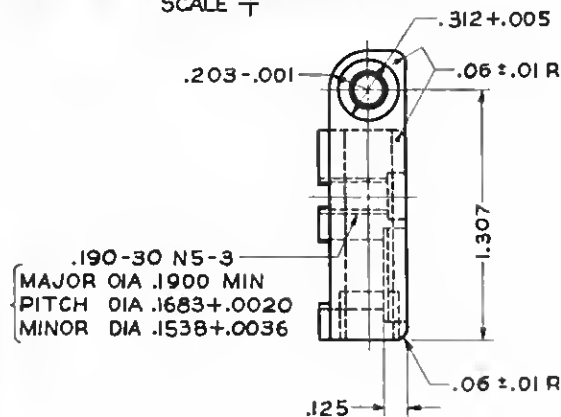
7110440

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

VIEW SHOWING ALTERNATIVE
METHOD OF MANUFACTURE

SCALE 1/1



INSCRIBE PART NUMBER

BODY, FRONT SIGHT

STEEL FSX1020

FINISH 125, OTHER SURFACES
AS SPECIFIED

6144237

SCALE 2/1

WAS 8144237

B 6144237

PHYSICAL
PROPERTIESY. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

MARCH 10, 1939

REVISIONS

11 5-10-48

DRG. PERTAINS TO

B 144235 30BMG M19A4
(FXD) & (FLEX)
B 7132923 30BMG M19A4
(FXD) & (FLEX)

DO

INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: 1/64
ANGULAR: 5°

DRAFTSMAN	TRACER	CHECKER	CHIEF DRAFTSMAN
H.D.C.	L.R.E.	5/10/48	

SUBMITTED:

H.A. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

ORD. DEPT. U. S. A.

ORONANCE DEPT. U. S. A.

B6144237

HEAT TREATMENT AND FINAL FINISH

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
VCL
SCL

FEBRUARY 25, 1947

REVISIONS

1 5-10-48

★POST, FRONT SIGHT, ASSEMBLY - B 7162616
PLUNGER-A5156881

SCREW-A5156884
SPRING-A5156882
⊕ SCREW-A5156883

STAKE
WASHER-A7110440

⊕ NOT REQ'D WHEN
ALTERNATIVE METHOD
OF MANUFACTURE OF
B6144237 IS USED.

STAKE

BODY-B6144237

SCREW-A5013258
SCREW-A5013249

SIGHT, BRACKET, GROUP ASSEMBLY (7)32923

SUPERSEDES B7132923 W/C 5-10-48



★ FINDING DIAGRAM

B 7132923

DRG. PERTAINS TO

51-83-1 M19A1 (FND)
30 BMG
51-84-1 M19A4 (FLEX)
30 BMG
51-125-1 M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNER O.E.R.	TECHER O.K.	CHECKER R.S.	CORR. DESIGNER C.O.
--------------------	----------------	-----------------	------------------------

SUBMITTED:

A.H. Roe
ORD. DEPT. U. S. A.

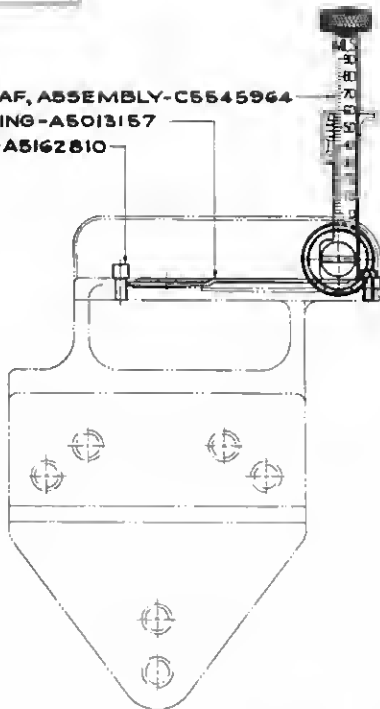
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter R. ...
ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

B7132923

HEAT TREATMENT AND FINAL FINISH

★ LEAF, ASSEMBLY-C5545964
 SPRING-A5013157
 PIN-A5162810



SIGHT, REAR, GROUP, ASSEMBLY

5564906

PLUNGER-A5013155
 SPRING-A5013154
 KNOB-B6000509
 LOCATE KNOB AND DRILL HOLE
 Ø625 ±.0010 DIA THROUGH SCREW,
 STAKE KNOB OVER ENDS OF PIN.
 PIN-A5013700
 BUSHING-A5159870
 SCALE-A5152430
 SCREW-A5013167
 SCREW-A5152429
 BASE-C5545965

PHYSICAL PROPERTIES		MARCH 10, 1939 REVISIONS	
Y P	7	5-10-40	
T S	8	10-21-48	
EL S	9	11-15-49	
RED			
BR			
ROCK			
SCL			

DRG. PERTAINS TO

51-03-1	30 SWS MISAL (F&D)
51-04-1	30 SWS MISAL (PL & S)
51-125-1	30 SWS MISAL

NOTE:
 STAKE BUSHING A5159870
 AT ASSEMBLY

★ FINDING DIAGRAM

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: 0.005
 FRACTIONAL: 1/16
 ANGULAR: 1/2

M.E.B. Z.C.

SUBMITTED:

A.H. Roe

WAS C64906

DO NOT
 DESCRIBE PART NO.

5564906

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE
 W.H. Robinson
 CHIEF, U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT WEST HAVEN, CONNECTICUT



5564906

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				MAY 1, 1929				
<i>DRAW AT 450°F</i>		Y.P.		RED.		ROCK.	REVISIONS			
		T.S.		BR.			16	12-18-41	22	2-7-44
		EL.2					17	2-11-42	23	7-28-49
<div style="border: 1px solid black; padding: 5px; display: inline-block;">DO NOT INSCRIBE PART NO.</div>		51-13 .30BAR-M18				18	2-19-42	24	3-24-49	
		51-125 .30BMG-M19A6				19	4-16-42	25	3-24-49	
						20	7-23-42			
						21	7-27-43			
<div style="font-family: monospace;"> Δ ☆ DIAMETER OF WIRE018 ☆ TOTAL NUMBER OF COILS 10 1/2 MINIMUM INSIDE DIAMETER, FREE Δ ☆ OUTSIDE DIAMETER, FREE118 ± .002 ☆ MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT .. .123 ☆ FREE LENGTH38 ± .030 Δ ☆ TYPE OF ENDS PLAIN ENDS GROUND ☆ WOUND R.H. MEAN ASSEMBLED HEIGHT25 Δ ☆ LOAD AT MEAN ASSEMBLED HEIGHT 2 LBS. ± .56 LBS. MINIMUM OPERATING HEIGHT206 Δ ☆ LOAD AT MINIMUM OPERATING HEIGHT 2.67 LBS. ± .75 LBS. LBS. PER INCH OF SPRING DEFLECTION 15. APPROX. SPRING FUNCTIONS IN HOLE125 SPRING FUNCTIONS OVER ROD ☆ CALCULATED MAXIMUM SOLID HEIGHT190 </div>		Δ CAUTION: DO NOT COMPRESS SOLID.		NOTE: 0.5% OF SPRINGS WILL BE FATIGUE TESTED BETWEEN ASSEMBLED HEIGHT AND MINIMUM OPERATING HEIGHT FOR 15,000 CYCLES. THE LOAD AT ASSEMBLED HEIGHT, AFTER TESTING, SHOULD NOT BE LESS THAN .32 LBS.						
		<u>SPRING, REAR SIGHT WINDAGE CLICK PLUNGER</u> STEEL WD 1085 SPECIAL USA SPEC 48-7-1 (CLASS A)				<div style="font-size: 2em; font-weight: bold;">5013154</div>				
		☆ MANUFACTURING DATA Δ MANDATORY REQUIREMENTS SUPERSEDES OLD TRACING A13154 UNDER REVISION DATE OF DEC. 18, 1941.				<div style="font-size: 2em; font-weight: bold;">A5013154</div> <div style="border: 1px solid black; padding: 5px; display: inline-block; margin-top: 10px;">A13154</div>				
						SUBMITTED: <i>[Signature]</i> LT. COL., ORD. DEPT. U.S.A. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>[Signature]</i> CAPT. ORD. DEPT. U.S.A. ORDNANCE DEPARTMENT, U.S.A.				

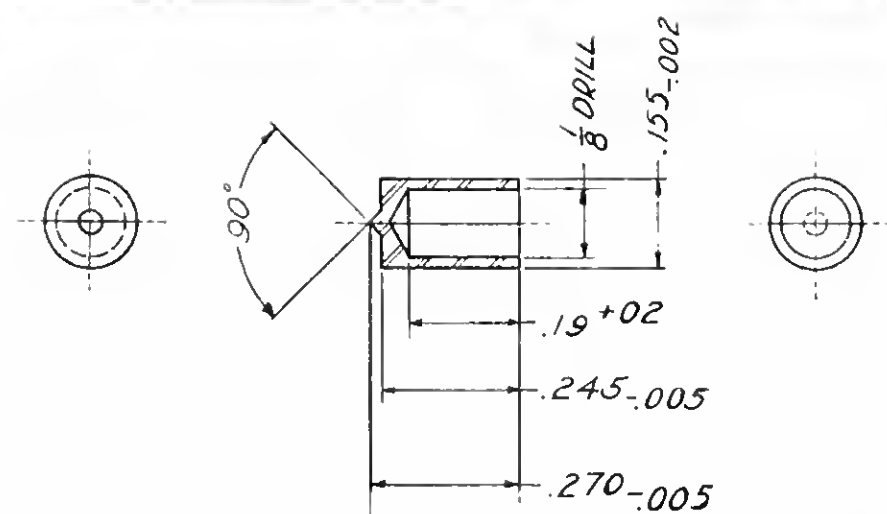
SUPERSEDES A13154

-13155

HEAT TREATMENT & FINAL FINISH
HEAT TREAT.
PROTECTIVE FINISH TYPE II CLASS A OR B.

PHYSICAL PROPERTIES					
Y.P.		RED.		SOL.	
T.S.		BR.			
EL 2		ROCK	A73-77		

MAY 1, 1929	
REVISIONS	
112	2-7-40 15 12-9-42
12	5-1-41 16 7-27-43
13	4-16-42 17 4-30-46
14	7-23-42 18 7-28-49



PLUNGER, REAR SIGHT WINDAGE CLICK
STEEL WD1085 COLD DRAWN
BREAK CORNERS
FINISH

5013155

(A13155-17)

TOLERANCE OF ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING A13155
UNDER REVISION DATE OF FEB. 7, 1940.

SCALE 4/1

DO NOT INSCRIBE PART NO.
A5013155
A13155

14 th 7-23-42 18 th 7-28-49		
DRG. PERTAINS TO		
51-102	30 BAR - M1918 A2	
51-70	50BMG-M2HB(FLEX)	
51-71	50BMG-M2HB(FXD)	
51-74	30BMG-M2HB(FXD)	
51-75	30BMG-M2HB(FLEX)	
51-77	30BMG-M19A2	
51-83	30BMG-M19A4(FXD)(ANK)	
51-84	30BMG-M19A4(FLEX)(ANK)	
51-88	50BMG-M2HB(FXD)	
C5564906	SIGHT, REAR ASSEM.	
D6528337	SIGHT, REAR GR ASSEM.	
D35377	SIGHT, REAR GR ASSEM.	
D6535423	SIGHT, REAR GR ASSEM.	
51-13	30 BAR M19	
51-126	30BMG-M19A6	
M.O.L.	26 3/4	G.P.T.
E.C.T.	10 1/2	75.51 17.00
J. H. Miller Sinter.		
MAU. AND DES. U.S.A.		
APPROVED BY ORDER OF THE CHIEF OF THE BUREAU OF THE ARMY		
J. N. Downing		
LT. COL. U.S. ARMY		
ORDNANCE DEPT. U.S.A.		

15-15 SUPERSEDES A13155

413157

15131051

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

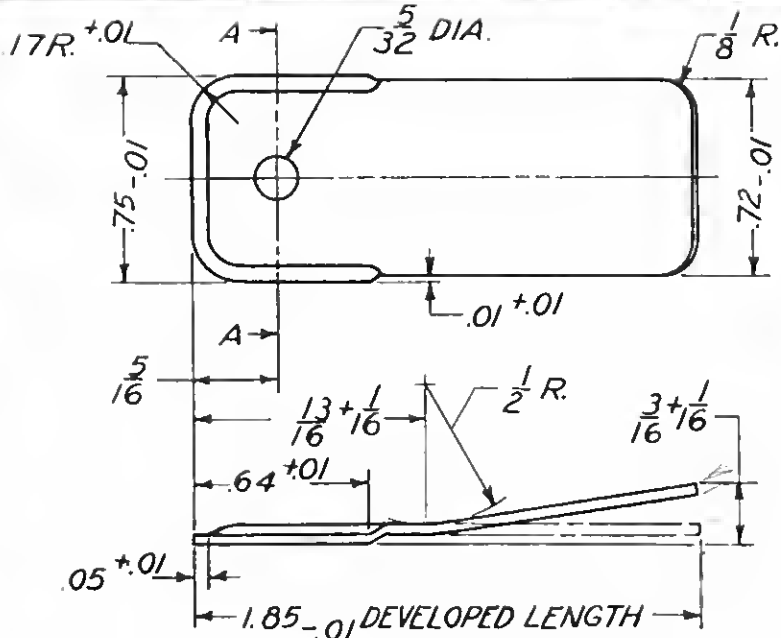
MAY 1, 1929

HEAT TREAT

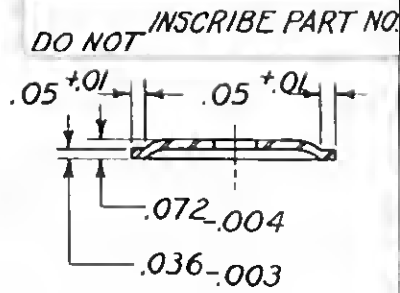
Y.P.		RED.		ROCK	A73-76
ELC		PR.			

TYPE II CLASS B

REVISIONS	
19	2-9-44
20	3-20-44
21	4-30-46
22	CONVERSION 7-28-49



XO 3200-8000
3440-2000
10,000 SPRINGS WERE
MADE TO REV. 9-25-40.
AND THEN MODIFIED TO
REV. 11-1-40



SECTION A-A

SPRING, REAR SIGHT BASE (A13157-21)
SPRING STEEL WD1095

NOTE: FOR ALTERNATIVE METHOD OF MANUFACTURE SEE DRG. A13157A

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING A13157
UNDER REVISION DATE OF FEBRUARY 9, 1944

SCALE 2

SPRINGFIELD ARMOY

A5013157

A13157

DRG. PERTAINS TO	
51-13	30BAR-M18
51-74	30BMG-M2HB(FXD)
51-75	30BMG-M2HB(FLEX)
51-77	30BMG-M19A2
51-83	30BMG-M19A4(FXD)
51-84	30BMG-M19A4(FLEX)
51-102	30BAR-M1918A2
51-125	30BMG-M19A6
C7416	SIGHT, REAR W/LATCH FIND. DIAG.
64906	SIGHT, REAR, ASM.
06535423	SIGHT, REAR, GRASM.
BCP	BCP
WEB	WEB
SUBMITTED	
 HORD ENG. BRD. DEPT. APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: LT COL. ORDN. DEPT. FORT MONMOUTH, N. J.	

SUPERSEDES A13157

A13167

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MAY 1, 1929

Y.P.

RED.

ROCK

REVISIONS

T₁

BR

1518-5-42

16117-42

171212-42

187-27-43

19430-46

203-30-49

DRG. PERTAINS TO

51-70 50 BMG-M2HB(FLEX)

51-71 50 BMG-M2HB(FXD)

51-74 30 BMG-M2HB(FXD)

51-75 30 BMG-M2HB(FLEX)

51-77 30 BMG-M19A2

51-83 30 BMG-M19A4(FXD)

51-84 30 BMG-M19A4(FLEX)

51-88 50 BMG-M2HB(FXD)

C5564305

C64206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

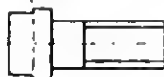
C74206 SIGHT, REAR, GRASM

C74206 SIGHT, REAR, GRASM

PROTECTIVE FINISH TYPE CLASS A OR B.

032 \pm .005

R-150R-65

OPTIONAL METHOD
OF CUTTING SLOT032 \pm .00504 \pm .01032 \pm .005

1/8



.086(N0.2)-64NF3

.148 \pm .020.203 \pm .015.285 \pm .010

5013167
SCREW, REAR SIGHT WINDAGE SCALE
STEEL WD.1112 COLD DRAWN
FINISH f

TOLERANCE \pm .01 ALLOWED ON ALL DIMEN-
 SIONS UNLESS OTHERWISE SPECIFIED.
 SUPERSEDES OLD TRACING A13167 UNDER
 REVISION DATE OF AUGUST 5, 1942.

SCALE $\frac{4}{1}$

DONOT INSCRIBE PART NO

 SPRINGFIELD ARMORY
 A5013167

A13167

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE

C. L. BUCKLEY COL. ORD. DEPT. U.S.A.

ORDNANCE DEPT. U.S.A.

15-15 SUPERSEDES A13167

A 5152429

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

REVISIONS

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

7 5-10-48

DRG. PERTAINS TO

C5564906

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIEDDECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{16}$ ANGULAR $\pm 1^\circ$

DRAFTSMAN

M.T.

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKED

L.S.

O.K.

CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

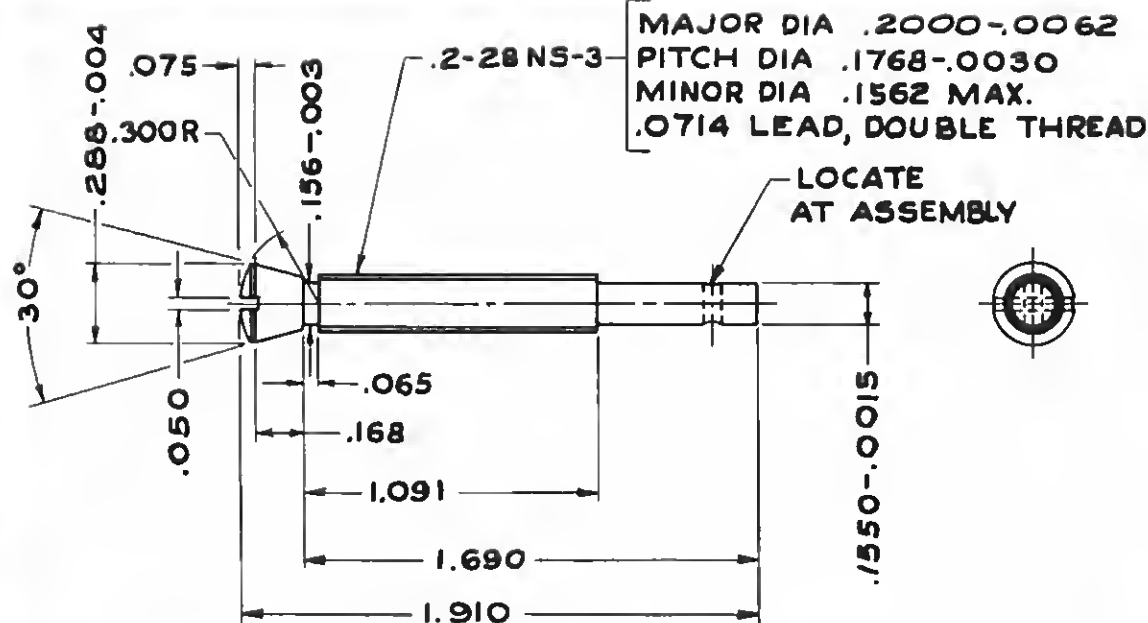
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. Arman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

SCREW, WINDAGE, REAR SIGHTSTEEL FSX1020

FINISH 125/

5152429

WAS A152429

SCALE $\frac{2}{1}$

A 5152429

A 5152430

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

8 5-10-48

DRG. PERTAINS TO

C5564906

30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL - .005

FRACTIONAL - -

ANGULAR - -

DRAFTSMAN

H.D.C.

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKED

LSC

CHIEF DRAFTSMAN

SUBMITTED:

H. Roe

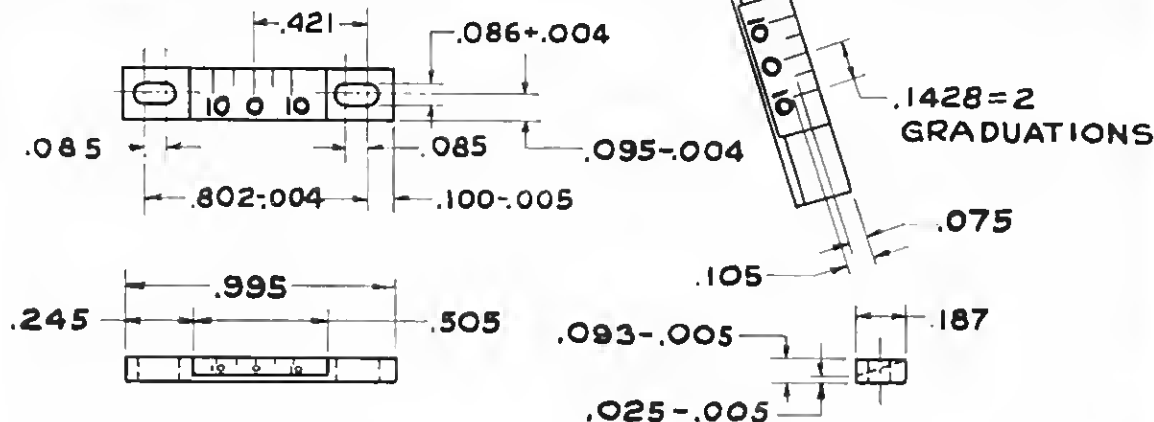
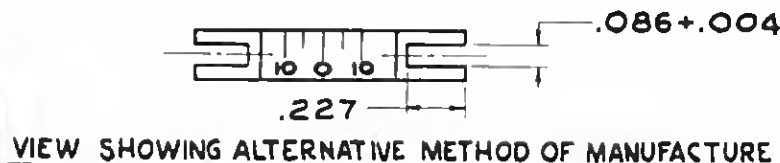
ORD DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:*Walter Ackerman*

ORD DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

NOTE:

GRADUATIONS .01 WIDE,
.005 DEEP, FIGURES .08
HIGH. FILL GRADUATIONS
AND FIGURES WITH
WHITE ENAMEL.

SCALE, WINDAGE, REAR SIGHT

STEEL FSX1020

FINISH 125/

5152430

WAS A152430

SCALE $\frac{2}{1}$

A 5152430

MARCH 10, 1939

HEAT TREAT
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES

Y. P.

RED.

SCL

T. S.

BR.

EL. 2

ROCK

C.C

.004 TO .006
DEFINITION

DEEF

REVISIONS

10	5-10-48
----	---------

DRG. PERTAINS TO

C5564906

.30 BMG
M19A4 (FXD)
M19A4 (FLEX)
M19A6

M19A4 (FXD)
M19A4 (FLEX)
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL+ .01

FRACTIONAL $\pm 1/64$

ANGULAR $\pm 5^\circ$

DRAFTSMAN

M.T.

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKED

~~LSC~~

CHIEF DRAFTSMAN

1998, 1999, 2000, 2001, 2002, 2003, 2004, 2005, 2006, 2007, 2008, 2009, 2010, 2011, 2012, 2013, 2014, 2015, 2016, 2017, 2018, 2019, 2020, 2021, 2022, 2023, 2024, 2025, 2026, 2027, 2028, 2029, 2030, 2031, 2032, 2033, 2034, 2035, 2036, 2037, 2038, 2039, 2040, 2041, 2042, 2043, 2044, 2045, 2046, 2047, 2048, 2049, 2050, 2051, 2052, 2053, 2054, 2055, 2056, 2057, 2058, 2059, 2060, 2061, 2062, 2063, 2064, 2065, 2066, 2067, 2068, 2069, 2070, 2071, 2072, 2073, 2074, 2075, 2076, 2077, 2078, 2079, 2080, 2081, 2082, 2083, 2084, 2085, 2086, 2087, 2088, 2089, 2090, 2091, 2092, 2093, 2094, 2095, 2096, 2097, 2098, 2099, 2100, 2101, 2102, 2103, 2104, 2105, 2106, 2107, 2108, 2109, 2110, 2111, 2112, 2113, 2114, 2115, 2116, 2117, 2118, 2119, 2120, 2121, 2122, 2123, 2124, 2125, 2126, 2127, 2128, 2129, 2130, 2131, 2132, 2133, 2134, 2135, 2136, 2137, 2138, 2139, 2140, 2141, 2142, 2143, 2144, 2145, 2146, 2147, 2148, 2149, 2150, 2151, 2152, 2153, 2154, 2155, 2156, 2157, 2158, 2159, 2160, 2161, 2162, 2163, 2164, 2165, 2166, 2167, 2168, 2169, 2170, 2171, 2172, 2173, 2174, 2175, 2176, 2177, 2178, 2179, 2180, 2181, 2182, 2183, 2184, 2185, 2186, 2187, 2188, 2189, 2190, 2191, 2192, 2193, 2194, 2195, 2196, 2197, 2198, 2199, 2200, 2201, 2202, 2203, 2204, 2205, 2206, 2207, 2208, 2209, 2210, 2211, 2212, 2213, 2214, 2215, 2216, 2217, 2218, 2219, 2220, 2221, 2222, 2223, 2224, 2225, 2226, 2227, 2228, 2229, 2230, 2231, 2232, 2233, 2234, 2235, 2236, 2237, 2238, 2239, 2240, 2241, 2242, 2243, 2244, 2245, 2246, 2247, 2248, 2249, 2250, 2251, 2252, 2253, 2254, 2255, 2256, 2257, 2258, 2259, 2260, 2261, 2262, 2263, 2264, 2265, 2266, 2267, 2268, 2269, 2270, 2271, 2272, 2273, 2274, 2275, 2276, 2277, 2278, 2279, 2280, 2281, 2282, 2283, 2284, 2285, 2286, 2287, 2288, 2289, 2290, 2291, 2292, 2293, 2294, 2295, 2296, 2297, 2298, 2299, 2300, 2301, 2302, 2303, 2304, 2305, 2306, 2307, 2308, 2309, 2310, 2311, 2312, 2313, 2314, 2315, 2316, 2317, 2318, 2319, 2320, 2321, 2322, 2323, 2324, 2325, 2326, 2327, 2328, 2329, 2330, 2331, 2332, 2333, 2334, 2335, 2336, 2337, 2338, 2339, 2340, 2341, 2342, 2343, 2344, 2345, 2346, 2347, 2348, 2349, 2350, 2351, 2352, 2353, 2354, 2355, 2356, 2357, 2358, 2359, 2360, 2361, 2362, 2363, 2364, 2365, 2366, 2367, 2368, 2369, 2370, 2371, 2372, 2373, 2374, 2375, 2376, 2377, 2378, 2379, 2380, 2381, 2382, 2383, 2384, 2385, 2386, 2387, 2388, 2389, 2390, 2391, 2392, 2393, 2394, 2395, 2396, 2397, 2398, 2399, 2400, 2401, 2402, 2403, 2404, 2405, 2406, 2407, 2408, 2409, 2410, 2411, 2412, 2413, 2414, 2415, 2416, 2417, 2418, 2419, 2420, 2421, 2422, 2423, 2424, 2425, 2426, 2427, 2428, 2429, 2430, 2431, 2432, 2433, 2434, 2435, 2436, 2437, 2438, 2439, 2440, 2441, 2442, 2443, 2444, 2445, 2446, 2447, 2448, 2449, 2450, 2451, 2452, 2453, 2454, 2455, 2456, 2457, 2458, 2459, 2460, 2461, 2462, 2463, 2464, 2465, 2466, 2467, 2468, 2469, 2470, 2471, 2472, 2473, 2474, 2475, 2476, 2477, 2478, 2479, 2480, 2481, 2482, 2483, 2484, 2485, 2486, 2487, 2488, 2489, 2490, 2491, 2492, 2493, 2494, 2495, 2496, 2497, 2498, 2499, 2500, 2501, 2502, 2503, 2504, 2505, 2506, 2507, 2508, 2509, 2510, 2511, 2512, 2513, 2514, 2515, 2516, 2517, 2518, 2519, 2520, 2521, 2522, 2523, 2524, 2525, 2526, 2527, 2528, 2529, 2530, 2531, 2532, 2533, 2534, 2535, 2536, 2537, 2538, 2539, 2540, 2541, 2542, 2543, 2544, 2545, 2546, 2547, 2548, 2549, 2550, 2551, 2552, 2553, 2554, 2555, 2556, 2557, 2558, 2559, 2560, 2561, 2562, 2563, 2564, 2565, 2566, 2567, 2568, 2569, 2570, 2571, 2572, 2573, 2574, 2575, 2576, 2577, 2578, 2579, 2580, 2581, 2582, 2583, 2584, 2585, 2586, 2587, 2588, 2589, 2590, 2591, 2592, 2593, 2594, 2595, 2596, 2597, 2598, 2599, 2600, 2601, 2602, 2603, 2604, 2605, 2606, 2607, 2608, 2609, 2610, 2611, 2612, 2613, 2614, 2615, 2616, 2617, 2618, 2619, 2620, 2621, 2622, 2623, 2624, 2625, 2626, 2627, 2628, 2629, 2630, 2631, 2632, 2633, 2634, 2635, 2636, 2637, 2638, 2639, 2640, 2641, 2642, 2643, 2644, 2645, 2646, 2647, 2648, 2649, 2650, 2651, 2652, 2653, 2654, 2655, 2656, 2657, 2658, 2659, 2660, 2661, 2662, 2663, 2664, 2665, 2666, 2667, 2668, 2669, 2670, 2671, 2672, 2673, 2674, 2675, 2676, 2677, 2678, 2679, 26

SUBMITTED:

A. H. Roe

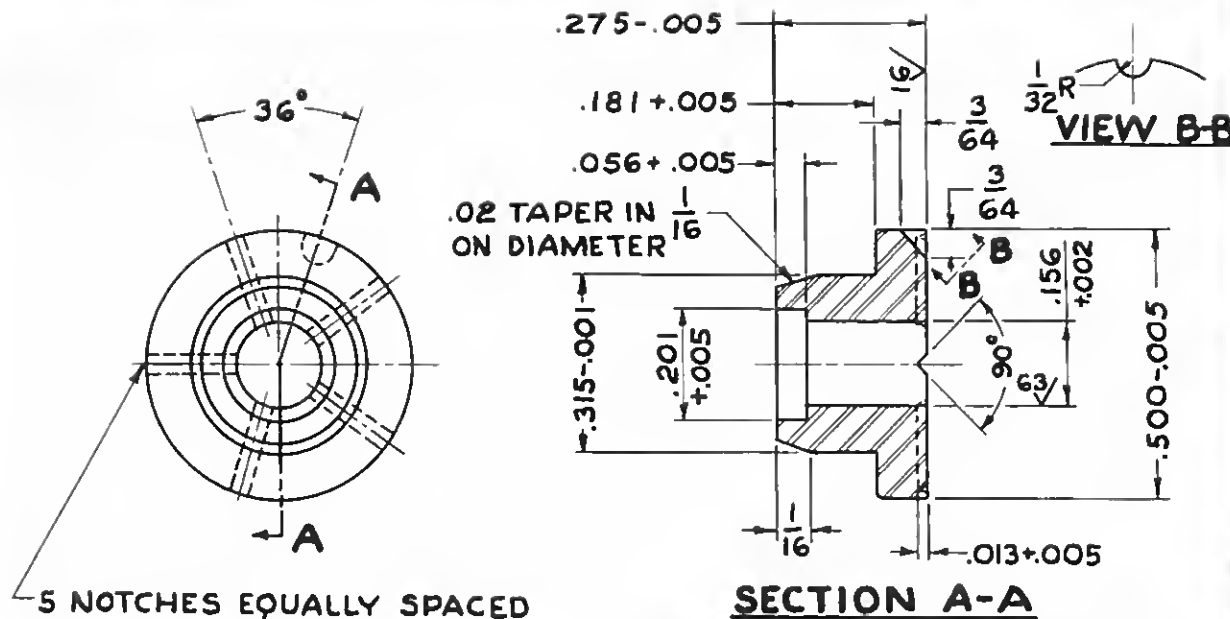
ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



BUSHING, REAR SIGHT WINDAGE SCREW (5159870)
STEEL FSX 1020

FINISH ¹²⁵/_✓, OTHER SURFACES AS SPECIFIED

WAS A159870

SCALE $\frac{4}{1}$

A 5159870

A5162810

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

MARCH 10, 1939

TYPE II FINISH, CLASS B

Y. P.

RED.

SCL.

T. S.

BR.

EL 2

ROCK

REVISIONS

6 5-10-48

DRG. PERTAINS TO

C5564906

30 BMS
M19A4 (FXD)
M19A4 (FLEX)
M19AG

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm -$

DRAFTSMAN

APB

TRACER

O.K.

L'D'G DRAFTSMAN

CHECKED

LSC

CHIEF DRAFTSMAN

O.O.

SUBMITTED:

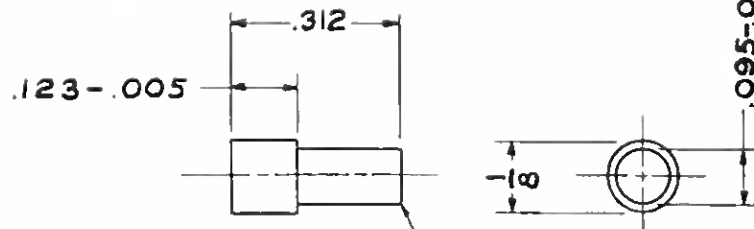
A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.



BREAK CORNER

PIN, STOP, REAR SIGHT LEAF (5162810)

STEEL FSX 1315

FINISH 125/

WAS A162810

SCALE $\frac{4}{1}$

A

5162810

PROTECTIVE FINISH TYPE II GLASS A O B

DO NOT INSCRIBE PART NO.

51-75

30 BMG M2H8/2EA

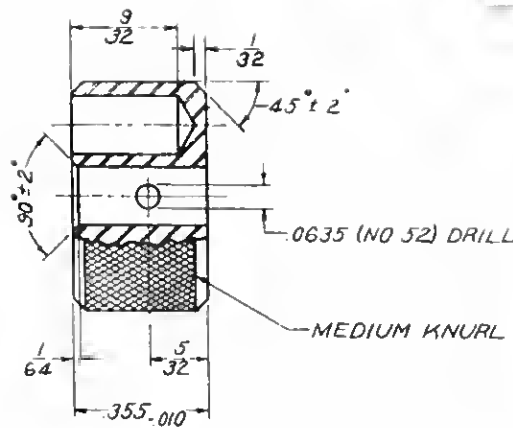
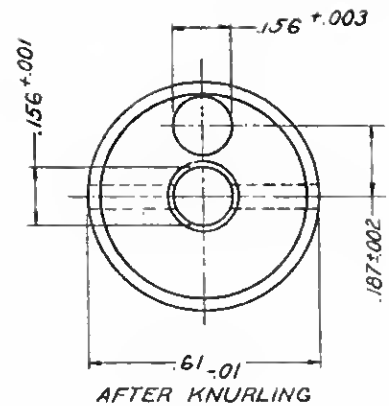
PHYSICAL PROPERTIES

APRIL 30, 1934

REVISIONS

Y.P.	21	4-15-11	
T.S.	22	5-6-11	
EL 2	23	4-16-11	
RED.	24	4-18-11	
BR.	25	3-20-11	
ROCK.			

DRG. PERTAINS TO



KNOB, REAR SIGHT WINDAGE SCREW
STEEL WD. 1112 COLD DRAWN
FINISH

6008809

~~(88809-23)~~

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING B8809 UNDER REVISION DATE OF APRIL 15, 1944.

SCALE $\frac{4}{1}$

SPRINGFIELD ARMOY
B 6008809

~~B 8809~~

Q. FTSMAN KMT	TRACER KMT	LOG. FTSMAN KMT
CHECKER KMT	CH. FTSMAN KMT	

SUBMITTED:

W. H. H. H. H.

ORDN. ENG. ORD. DEPT.

APPROVED BY ORDER OF THE
CHIEF OF ORDNANCE:

W. H. H. H. H.

LT COL. ORD. DEPT.

ORDNANCE DEPT., U.S.A.

SUPERSEDES B8805

86008803

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B
SPEC 57-0-2

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JUNE 1, 1931

REVISIONS

10 5-10-48
11 11-15-49

DRG. PERTAINS TO

C550977 .30 BMG
M17A1(WC)
C5564096 .30 BMG
M19A4(FXD)
M19A4(FLEX)
M19A5(FXD)
M19A6

~~DO~~ INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± —
FRACTIONAL ± —
ANGULAR ± —

DESIGNER	TRACER	L.D.G. DRAFTSMAN
C.S.S.	E.R.G.	
CHECKER	CHIEF DRAFTSMAN	

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

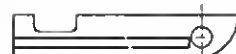
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

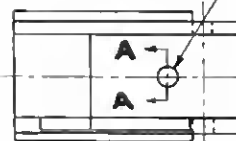
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL



STUD-A5009363



SLIDE-C5508467



SECTION A-A

SCALE $\frac{4}{1}$

SLIDE, FEEDBELT, ASSEMBLY

6131262



WAS 8131262

B 6131262

6131262

ORDNANCE DEPT. U.S.A.

HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B
SPEC 57-0-2

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JUNE 1, 1931

REVISIONS

10 5-10-48
11 11-15-49

DRG. PERTAINS TO

C5509177 .30 BMG
M1A1(WC)
C5564096 .30 BMG
M19A4(FXD)
M19A4(FLEX)
M19A5(FXD)
M19A6

~~DO~~ INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL ± —
FRACTIONAL ± —
ANGULAR ± —

DESIGNER C.B.S.	TRACER E.R.G.	L.D.G. DRAFTSMAN
CHECKER C.B.S.	CHECK DRAFTSMAN	

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

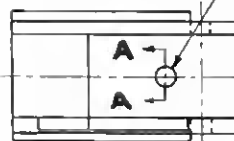
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL



STUD-A5009363



SLIDE-C5508467



SECTION A-A

SCALE $\frac{4}{1}$

SLIDE, FEEDBELT, ASSEMBLY

6131262



WAS 8131262

B 6131262

86131262

HEAT TREAT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL .008
FRACTIONAL 1/64
ANGULAR 2°

DRAWING M.F.D.	TAP DR L.R.E.	NO DESCRIPTIONS
--------------------------	-------------------------	-----------------

SUBMITTED:
A.H.Koz
O&D DEPT L.S.*

APPROVED BY ORDER OF THE C.W.B.
OF ORIGINALS
Hester Beckman
C.A.S. CAPT U.S.A.

ORDNANCE DEPT., U. S. A.

SCALE $\frac{2}{1}$ 15508467

HEAT TREATMENT AND FINAL FINISH

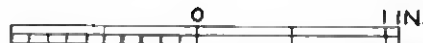
TYPE II FINISH, CLASS B

SPRING-B6017485

PIN-A5020577

SPRING, SEAR, ASSEMBLY

6131265

PHYSICAL
PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCL.

JUNE 1, 1931

REVISIONS

11 5-10-48

DRG. PERTAINS TO

51-10-1	30 BMG MITAI (WC)
51-83-1	30 BMG M19A4 (FXD)
51-84-1	30 BMG M19A4 (FLY)
51-114-1	30 BMG M19A5 (FXD)
51-125-1	30 BMG M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL: —

FRACTIONAL: —

ANGULAR: —

DESIGNER	TRACER	C.D. & DRAFTSMAN
E.C.P.	A.V.C.	
CHECKER		CHIEF DRAFTSMAN

SUBMITTED:

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B131265

B 6131265

B6131265

A 5020577

JUNE 1, 1931

HEAT TREATMENT & FINAL FINISH

PHYSICAL PROPERTIES

HEAT TREAT $\frac{1}{2}$ INCH OF BEVELED END

Y. P.

RED.

SCL.

T. S.

BR.

EL. 2

ROCK

C55-60

REVISIONS

12 5-10-48

DRG. PERTAINS TO

B6131265

30 BMG
 M17A1 (WC)
 M19A4 (FXD)
 M19A4 (FLEX)
 M19A5 (FXD)
 M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED

DECIMAL .005
 FRACTIONAL $\frac{1}{64}$
 ANGULAR 2°

DRAFTSMAN

W.C.O.

TRACER

L.R.E.

LDG DRAFTSMAN

CHECKER

LSC

CHIEF DRAFTSMAN

SUBMITTED:

A.M. Roe

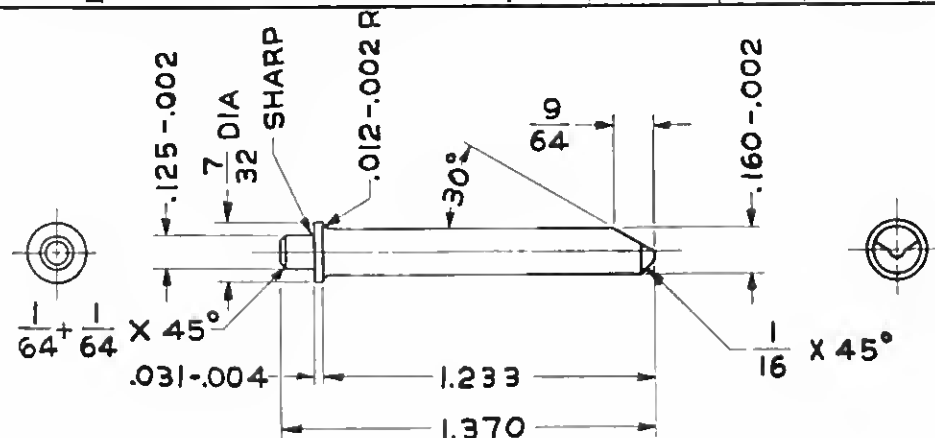
ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
 OF ORDNANCE:

Walter Ackerman

ORD. DEPT., U. S. A.

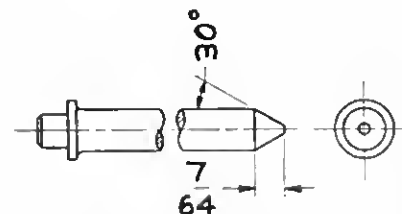
ORDNANCE DEPT., U. S. A.

**PIN, SEAR SPRING**

DRILL ROD

FINISH $\frac{125}{\sqrt{}}$

5020577



ALTERNATIVE METHOD
 OF MANUFACTURE

WAS A20577

SCALE $\frac{2}{1}$

A 5020577

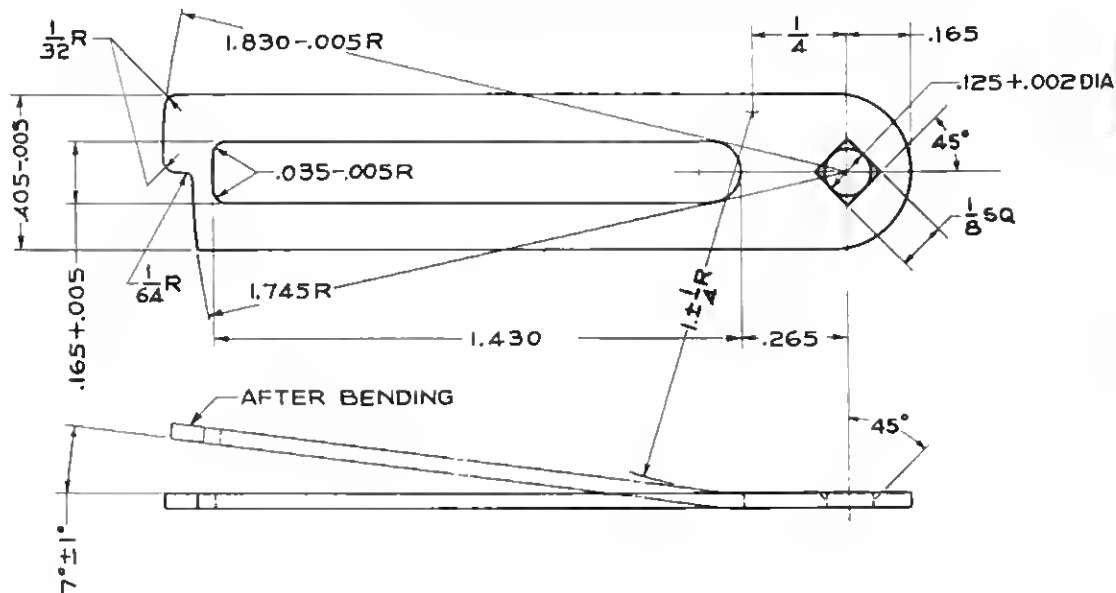
MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT

NOTE:

THE $\frac{1}{8}$ SQ X 45° CHAMFER ON UPPER EDGE OF HOLE
MAY BE OMITTED WHEN ALTERNATIVE METHOD OF
MANUFACTURE FOR A5020577 IS USED.



SPRING SEAR
 SPRING STEEL WDI095
 NO. 19 (.0418) U.S. GAGE THICK
 FINISH $\frac{125}{V}$

6017485

WAS B17485

SCALE $\frac{4}{1}$ B 6017485PHYSICAL
PROPERTIES

Y. P.

T. S.

EL. 2

RED

BR

RCL

SCL

A75-77

JUNE 1, 1931

REVISIONS

13 5-10-48

DRG. PERTAINS TO

B6131265

M 17A1 (WC)
 M 19A4 (FXD)
 M 19A4 (FLEX)
 M 19A5 (FXD)
 M 19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
 NOT OTHERWISE SPECIFIED
 DECIMAL: .005
 FRACTIONAL: $\frac{1}{64}$
 ANGULAR: 5°

REVISION	DATE	BY	CHK'D
C.S.S.	E.B.		
			CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman

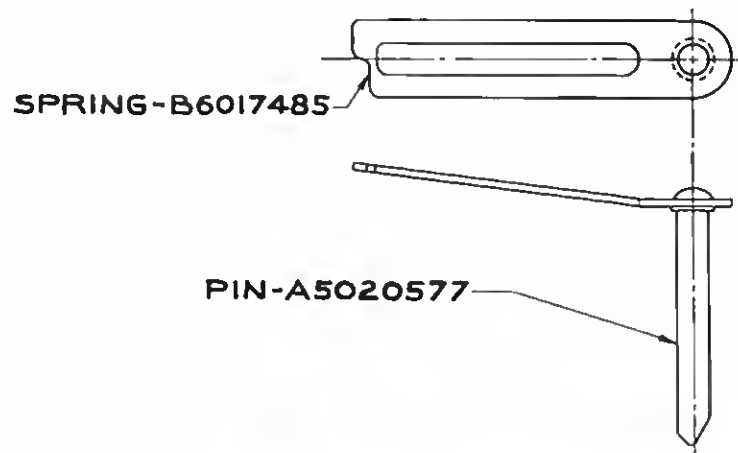
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6017485

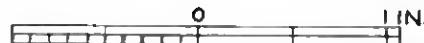
HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B



SPRING, SEAR, ASSEMBLY

6131265



PHYSICAL PROPERTIES

Y. P.
T. S.
EL. 2
RED
BR.
ROCK.
SCI.

JUNE 1, 1931

REVISIONS

11 5-10-48

DRG. PERTAINS TO

51-10-1 30 BMG
MITAI (WC)
51-83-1 30 BMG
M19A4 (FXD)
51-84-1 M19A4 (FLY)
51-114-1 30 BMG
M19A5 (FXD)
51-125-1 30 BMG
M19A6

INSCRIBE PART NO.

DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: —
FRACTIONAL: —
ANGULAR: —

DESIGNER E.C.P.	TRACER A.V.C.	C.O. & DRAFTSMAN
CHECKER S.P.	GR	CHIEF DRAFTSMAN

SUBMITTED:

J.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

WAS B131265

B 6131265

B6131265